MIG NIX

Classification

ISO 18274	:	S-Ni 6002 (NiCr21Fe18Mo9)	Material N°	:	2.4613
AWS A5.14	:	ERNiCrMo-2	AMS	:	5798

Description & Applications

Solid wire for GMAW of Nickel alloys, popularly known as HASTELLOY X®. Nickel base alloy generally used in turbines and engines. Best compromise between resistance to oxidation and mechanical characteristics at high temperature.

Main applications: Used in the aeronautical industry (combustion chamber, etc).

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Typical Chemical Composition (%)

C	Si	Mn	Cr	Fe	Mo	Co	W	Al	Cu	Ni
0.07	0.3	0.6	22.0	19.3	8.5	1.0	0.8	0.3	0.25	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
420	680	23

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +				Ar + He Ar/He + 0.05% CO_2 18-20 l/min

Ind.10

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