

ERNiCr-6 (NiCr 80:20)

Solid Welding Wire or Rod Solid Welding wires and rods for GMAW, GTAW and SAW acc. EN 13479

Main Applications:

ERNiCr-6 is used for welding nickel-chromium-iron alloy such as UNS N06600 and N06075 to itself, for the clad side of joints in steel clad with nickel-chromium-iron alloy, for surfacing steel with nickel-chromium-iron weld metal, and for joining steel to nickel-base alloys using the tungsten inert gas welding, gas-shielded metal arc welding, submerged arc welding, and plasma arc welding.

Standard specifications:

Alloy name*	Product forms	AWS		UNS	DIN 1736
ERNiCr-6	MIG/TIG/SAW welding wire or rod	A5.14	ERNiCr-6	N06076	2.4639

Chemical Composition: acc. AWS 5.14

	Alloy name	Ni% (min)	Cu%	Ti%	Cr%	Mn%	Fe%	C%	Si%	Al%	S%
AWS	ERNiCr-6	75	0.50	0.15-0.50	19-21	1.0	2.0	0.08-0.15	0.30	0.40	0.015
VZPS	ERNiCr-6	75	0.50	0.15-0.50	19-21	1.0	2.0	0.08-0.15	0.30	0.40	0.015

*Or under customer needs

Mechanical properties:

Tensile strength: 550 MPa (80 psi)
 Elongation: 25%

Dimensions:

Product	Diameter, mm	Length, mm	Packing
Welding wire (MIG)	0.8, 1.0, 1.2, 1.6, 2.0, 2.4, 2.5, 3.2	-	S300/K300
Welding rods (TIG)	2.0, 2.5, 3.2, 4.0, 5.0	915 - 1000	Box
Electrode core wire	2.0, 2.5, 3.20, 3.25, 4.0, 5.0	250, 300, 350, 400, 450, 500	Box

** Or lengths under customer needs

Condition of Supply:

Binary Nickel-Iron (Ni-Fe) and Ni based complex welding alloys are supplied in welding rod and wires in standard length or length up to the consumers' request. For normal service conditions, the chemical compositions are available in various Ni contents according to the most of American and European standards.