NOUVE® NiCrMo-3

Designation

AWS A5.11 ENiCrMo-3
UNS No. W86112

Welding Positions

Features

- Excellent arc characteristics
- Low spatter level
- Quick & easy slag removal
- Low moisture re-absorption
- Low smoke level
- Radiography quality

Applications

Used extensively in overlaying, and cladding where a similar chemical composition is required.
Dissimilar joints between nickel-chromium-molybdenum alloys to stainless steels, carbon or low alloys steels

Recommended Welding Techniques

GENERAL : Electrode positive, work negative (DCEP)
ARC LENGTH : Short arc
STORAGE : Re-dry electrodes to 300°C for 2 hours before use

Weld Metal Chemistry

	Carbon (C)	Manganese (Mn)	Iron (Fe)	Sulphur (S)	Silicon (Si)	Copper (Cu)	Nickel (Ni)	Chromium (Cr)	Nb+Ta	Molybdenum (Mo)
AWS SPEC	0.1 Max	1.0 Max	7.0 Max	0.02 Max	0.75 Max	0.50 Max	55.0 Min	20.0-23.0	3.15-4.15	8.0-10.0
TYPICAL	0.064	0.62	5.82	0.016	0.44	0.38	57.02	22.24	3.82	9.24

Mechanical Properties (as welded)

MECHANICAL TESTS	Tensile Strength	Elongation %
AWS SPEC	760 MPa Minimum	30 % Minimum
TYPICAL	810 MPa	33%