

NOUVE[®] NiCrMo-4

Designation

Welding Positions

AWS A5.11 ENiCrMo-4
UNS No. W80276



Features

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

Applications

Joining Cr-Ni-Mo austenitic steel to duplex stainless steels and 9% Ni steel for cryogenic applications, forging dies for service applications from -200°C to 1000°C. High-grade welding of high Mo Nickel base alloys.

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)	Silicon (Si)	Copper (Cu)	Nickel (Ni)	Cobalt (Co)	Chromium (Cr)	Molybdenum (Mo)	Tungsten (W)
AWS SPEC	0.02 Max	1.0 Max	4.0 - 7.0	0.2 Max	0.50 Max	Rem	2.5 Max	14.5 - 16.5	15.0 - 17.0	3.0 - 4.5
TYPICAL	0.015	0.56	4.54	0.12	0.22	59.52	0.2	15.48	15.62	3.34

Mechanical Properties (as welded)

MECHANICAL TESTS	Tensile Strength	Elongation %
AWS SPEC	690 MPa Minimum	25 % Minimum
TYPICAL	760 MPa	32%