

NOUVE T-NiCrMo-10

ASME SFA-5.14/SFA-5.14M ERNiCrMo-10

UNS No: N06022

DESCRIPTION:

- ERNiCrMo -10 is a nickel-chrome-molybdenum alloy of type alloy C-22.
- This alloy also provides a tough Nb-free weld metal for dissimilar welds in super austenitic and super duplex stainless steel or combinations of these with Ni base alloys.
- This alloy offers an outstanding resistance to stress corrosion cracking, pitting and crevice corrosion.

APPLICATION:

- ERNiCrMo-10 is designed to handle a broad range of industrial welding applications, such as petroleum, chemical, and power generation plants, as well as offshore and marine facilities.

CHEMICAL COMPOSITION OF DEPOSITED METAL (wt%) :

ELEMENTS	AWS SPEC	TYPICAL
Carbon (C)	0.015 max	0.004
Manganese (Mn)	0.50 max	0.10
Iron (Fe)	2.0-6.0	4.0
Phosphorus (P)	0.020 max	0.006
Sulphur (S)	0.010 max	0.001
Silicon (Si)	0.080 max	0.05
Copper (Cu)	0.50 Max	0.02
Nickel (Ni)	Rem	56.0
Chromium (Cr)	20.0-22.5	21.90
Tungsten (W)	2.50-3.50	3.10
Molybdenum (Mo)	12.50-14.50	13.60
Cobalt (Co)	2.50 Max	0.01
Vanadium	0.35 Max	0.02

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MECHANICAL PROPERTIES OF DEPOSITED METAL:

MECHANICAL TESTS	AWS SPEC	TYPICAL
Tensile Strength	690 MPa Minimum	730 MPa

RECOMMENDED WELDING TECHNIQUES:

Current/Polarity : DCEN
Shielding Gas : 100% Ar

SIZE (mm)	AMPERAGE (A)	VOLTAGE (V)	GAS FLOW RATE (lpm)
1.60 x 1000	80-110	13-16	10-15
2.00 x 1000	90-130	14-18	10-15
2.40 x 1000	120-175	15-20	10-15
3.20 x 1000	150-200	15-20	10-15

PACKING:

SIZE (mm)	PACKING MODE	WEIGHT (kgs.)
1.60 x 1000	PLASTIC TUBULAR BOX	5.0
2.00 x 1000	PLASTIC TUBULAR BOX	5.0
2.40 x 1000	PLASTIC TUBULAR BOX	5.0
3.20 x 1000	PLASTIC TUBULAR BOX	5.0