

NOUVE T-NiCrMo-4

ASME SFA-5.14/SFA-5.14M ERNiCrMo-4

UNS No: N10276

APPLICATIONS:

- ERNiCrMo-4 is used for gas tungsten arc welding of Inconel alloy C-276 and other nickel-chromium molybdenum alloys.
- The weld metal has excellent corrosion resistance in many aggressive media and is especially resistant to pitting and crevice corrosion.
- Suitable for valves, valve seats, impellers, guide points, bushings, bearings, journals, hot working tools like hot shear blades, forging dies, trimming dies, piercing punches ,etc..

CHEMICAL COMPOSITION OF DEPOSITED METAL (wt%) :

ELEMENTS	AWS SPEC	TYPICAL
Carbon (C)	0.02 Max	0.018
Manganese (Mn)	1.00 Max	0.50
Iron (Fe)	4.0 – 7.0	5.30
Phosphorus (P)	0.04 Max	0.007
Sulphur (S)	0.03 Max	0.003
Silicon (Si)	0.08 Max	0.030
Copper (Cu)	0.50 Max	0.050
Nickel (Ni)	Rem	58.0
Chromium (Cr)	14.5 – 16.5	15.90
Molybdenum (Mo)	15.0 – 17.0	16.0
Cobalt (Co)	2.50 Max	0.36
Vanadium (V)	0.35 Max	0.180
Tungsten (W)	3.0-4.50	3.40
Others	0.50 Max	0.20

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MECHANICAL PROPERTIES OF DEPOSITED METAL:

MECHANICAL TESTS	AWS SPEC	TYPICAL
Tensile Strength	690 MPa Minimum	720 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