

CODIFICATION: AWS/SFA 5.14: ERNiCrMo-3

CHARACTERISTICS AND APPLICATIONS:

FW 1223 is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. It is ideal for welding Ni-Cr-Mo alloys to themselves and to steel, and for surfacing steel. The wires are use in applications where the temperature ranges from cryogenic to 540°C. It is also suitable for welding Ni base alloys to steel. Ideal for valves, valve seats, impellers, guide points, bushing, bearings, journals, hot working tools like hot shear blades, forging dies, trimming dies, piercing punches etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	P	S	Cr	Ni	Mo	Fe	Al	Cu	Ti	Nb+Ta
Percent	0.06	0.40	0.30	0.015	0.008	21.0	Rem.	9.0	4.0	0.20	0.25	0.20	3.5

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L=4d) %
770	34.0

SHIELDING GAS : Argon

CURRENT CONDITIONS : DCEN

WELDING POSITION : H, F, VU, OH

PACKING:

STANDARD SIZE	Diameter 1.6 mm, 2.0 mm, 2.5 mm & 3.2 mm in cut lengths of 1000 mm each.
QUANTITY	5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on both the sides of wire.

An ISO 9001: 2008 certified company

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