

**CODIFICATION: AWS / SFA 5.14: ERNiCrCoMo-1**

**CHARACTERISTICS AND APPLICATIONS:**

FW 1225 is a solid wire for GTAW available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. It is used for welding Nickel-Chromium-Cobalt-Molybdenum alloys to themselves and to steel and for surfacing steel with Ni-Cr-Co-Mo weld metal. It is also used for applications where optimum strength and oxidation resistance is required above 820°C up to 1150°C especially when welding on base metal of Nickel-Iron-Chromium alloys. Specially recommended for welding furnace heating elements, reformer tubes etc.

**TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:**

Element	C	Mn	Fe	P	S	Si	Cr	Ni	Mo	Co	Ti	Cu	Al
Percent	0.08	0.80	1.5	0.015	0.008	0.30	22.0	53.0	9.0	12.0	0.20	0.20	1.10

**TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:**

UTS (MPa)	Elongation (L=4d) %
<b>620</b>	<b>25.0</b>

**SHIELDING GAS : Argon**

**CURRENT CONDITIONS : DCEN**

**WELDING POSITION : H, F, VU, OH**

**PACKING:**

<b>STANDARD SIZE</b>	Diameter 1.6 mm 2.0 mm, 2.50 mm & 3.20 mm in cut lengths of 1000 mm each.
<b>QUANTITY</b>	5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – Brand name is punched on both the sides of wire.

**An ISO 9001: 2008 certified company**

**D & H Sécheron Electrodes Pvt. Ltd.**

44-46, Industrial Estate, Kila Maidan, Indore-452 006, India, Ph: 0731 2412331-2, 4229222 Fax: 0731 4229260  
e-mail: info@dnhsecheron.net Website: www.dnhsecheron.com