

**CODIFICATION: AWS/SFA 5.14: ERNiCu-7**

**CHARACTERISTICS AND APPLICATIONS:**

FW 1250 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. The weld metal possesses good resistance to corrosion by seawater, chlorinated solvents, sulfuric acid and alkalis. It is ideally suited for welding of monel-to-monel, Ni-Cu alloys to themselves, Ni-Cu alloy to steels, for welding clad side of Ni-Cu clad steel and for surfacing on steel parts. It is ideal for marine, chemical, food, dairy and oil refining industries.

**TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:**

Element	C	Mn	Si	P	S	Ni	Cu	Ti
Percent	0.025	0.87	0.16	0.010	0.006	63.8	31.0	2.50

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

UTS (MPa)	Elongation (L=4d) %
520	30.0

**SHIELDING GAS** : Argon

**CURRENT CONDITIONS** : DCEN

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

**PACKING:**

<b>STANDARD SIZE</b>	Diameter 1.6 mm, 2.0 mm, 2.5 mm & 3.2 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 – AWS code is punched on both the sides of wire.

**An ISO 9001: 2008 certified company**

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

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