

CODIFICATION: AWS/SFA 5.14: ERNiCrMo-10

CHARACTERISTICS AND APPLICATIONS:

FW 1423 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 weld deposit. Weld metal enhanced resistance to pitting, crevice corrosion, and stress corrosion cracking. It has outstanding corrosion resistance to both reducing and oxidizing media. It is suitable for welding Nickel – Chromium – Molybdenum alloy to itself, to steel, to other nickel base alloys, and for cladding steel. Typical applications include the welding of Nickel – Chromium – Molybdenum alloys such as, ASTM B574, B575, B619, B622 & B628 having UNS number N 06022.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

| Element | C | Mn | Fe | P | S | Si | Ni | Co | Cr | Mo | V | W |
|---------|-------|------|-----|-------|-------|------|------|-----|------|------|------|-----|
| Percent | 0.010 | 0.40 | 4.5 | 0.015 | 0.008 | 0.07 | Rem. | 2.0 | 21.0 | 13.0 | 0.20 | 3.0 |

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

| UTS (MPa) | Elongation (L=4d) % |
|------------|---------------------|
| 740 | 30.0 |

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

D & H Sécheron Electrodes Pvt. Ltd.

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