FW NiCr-3

Solid Wire for GTA / TIG Welding

CLASSIFICATION: **AWS SFA 5.14** **ERNiCr-3**

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

CHARACTERISTICS:

FW NiCr-3 is a solid wire available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds.

APPLICATIONS:

This wire is used for welding a range of Inconel 600, 601, 690, Incoloy 800, 800H, 800HT, 9% Nickel steel, ASTM B 163, B 166, B 167, B168 etc. Used for dissimilar applications with carbon steel to stainless steels, low alloy steel to stainless steel and also for 200 and 400 type alloys.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Fe	S	P	Si	Ni	Cu	Co	Ti	Cr	Nb+Ta
Percent	0.08	3.00	2.0	0.008	0.015	0.20	Rem	0.20	0.004	0.50	20.0	2.5

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	% EL (L=4d)
600	32.0

SHIELDING GAS:	Argon

CURRENT CONDITIONS:	DCEN

PACKING:	STANDARD SIZE	Diameter 1.6 mm 2.0 mm, 2.50 mm & 3.20 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 – Brand name is punched on each wire.

An ISO 9001: 2008 certified company

D&H Sécheron Electrodes Private Limited

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October 27, 2014 (Rev.: 02)