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REASON FOR ISSUE

A comment clarifying "Others" added. TÜV added

GENERAL

Bare Ni-Cr rods for welding of high alloyed heat-resisting and corrosion resisting materials, 9%Ni-steels and similar steels with high notch toughness at low temperatures. Also for joining of dissimilar metals of the types mentioned. The weld metal has very good mechanical properties at high and low temperatures. Good resistance to stress corrosion.

Shielding Gas: I1, R1 (EN 439)

Alloy Type: Alloyed nickel (Ni + 20 % Cr + 3 % Mn + 2.5 % Nb)

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.14 ERNiCr-3
EN ISO 18274 S Ni 6082 (NiCr20Mn3Nb)

APPROVALS

VdTÜV 12657 (MV)
VdTÜV 12667 (FP)

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C		0.05
Si		0.25
Mn	2.50	3.50
P		0.010
S		0.010
Cr	18.0	22.0
Ni	67.0	
Co		0.05
Cu		0.07
Ti		0.70
Fe		1.5
Nb+Ta	2.30	3.00
Others tot		0.50

Comments:
Others tot. also include Co.

OTHER DATA

The rods are used for welding of e.g.

Ni-alloy type:

600 (Werkstoffnr 2.4816)

9%Ni.steel: X 8Ni9