Nichrofer® C-4

Ni-base solid wire

Classification

AWS A5.14/A5.14M	:ERNiCrMo-13
ISO 18274	:S Ni 6059 (NiCr23Mo16)

General Description

Solid wire for welding nickel base alloys with high CrMo content
Excellent resistance against pitting, stress, and crevice corrosion in acid sulfur phosphorus and chlorine surroundings
Suitable for dissimilar joints

Shielding gas (acc. EN)

GMAW	I1	Inert gas Ar 100%
	I3	Inert gas Ar + > 0-95% He

Approvals

	TÜV
GTAW	+

Chemical composition (w%), typical, all weld metal

C	Mn	Si	Cr	Ni	Mo	Fe	Al
0.015	0.5	0.06	23	59	16	1.5	0.4

Mechanical properties, all weld metal

	Process	Shielding gas	Condition	0.2% Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Elongation (%)	Impact (ISO), J +20 °C	Impact (ISO), J -196 °C
Typical values after welding	GTAW	I1	AW	400	720	30		

Materials to be welded

Material grades such as:	DIN 17744	W.Nr.	ASTM/ACI	UNS
Ni-base high CrMo steel	NiCr23Mo16	2.4605		N06059
	NiMo16Cr16Ti	2.4610	C-4	N06455
	NiMo16Cr15Ti	2.4819	C-276	N10276
	NiCr21Mo14W	2.4602	C-22	N06022
	NiCr22Mo9Nb	2.4856	625	N06625
High Mo-steel stainless steel	EN 10088-1/-2			
for high corrosion environments	X1 NiCrMoCuN25-20-7	1.4529	904hMo	N08925
	X1 CrNiMoCuN20-18-7	1.4547		S31254

Packaging, available sizes and identification

Process	Unit:	Sizes, mm 2.0
GTAW	2kg tube	X

Other sizes and packaging on request

Identification	Imprint: Nichrofer®C-4	Tip colour:	Nichrofer®C-4 : rev.EN 20