

LNT/LNM NiCro 70/19

Ni-base solid wire

Classification

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

General description

Solid wire for welding nickel based alloys, dissimilar metals and cladding
High resistance to oxidation and high impact toughness at low temperature

Shielding gases (acc. EN 439)

GTAW/GMAW I1 Inert gas Ar (100%)
I3 Inert gas Ar+ >0-95% He

Approvals

	TÜV
GTAW	+
GMAW	+

Chemical composition (w%). typical wire / rod

C	Mn	Si	Ni	Cr	Nb	Fe	Cu
0.03	3.1	0.08	72.5	20.5	2.6	0.8	0.01

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
							+20°C	-196°C
Typical values	GTAW	I1	AW	400	680	40	150	120
	GMAW	I1	AW	390	640	35	150	50

Materials to be welded

Material type	BS3076	DIN 17744/17465 SEW 595	W.Nr.	ASTM/ACI B366	UNS
Ni-base high Cr alloyed steel for low and high corrosion searching application	Na 14	NiCr15Fe	2.4816	B168-Alloy 600	N06600
		LC-NiCr15Fe	2.4817	Alloy 600L	N06600
		NiCr20Ti	2.4951	Alloy 75	
	Na 15	NiCr20TiA1	2.4952	Alloy 80A	N07080
		X10NiCrAlTi32 20	1.4876	Alloy 800/800H	N0800/10
		NiCr23Fe	2.4851	Alloy 601(H)	N06601
	Na 17	X12NiCrSi36 16	1.4864	330	N08330
		G-X40NiCrNb35 25	1.4852		
		G-X40NiCrSi35 25	1.4857	HP	

Un- and low alloyed heat and creep resistant steel to stainless steel

Application advice

Limit heat-input (HI<1.5kJ/mm) and interpass temperature (TI<150°C)

Packaging and available sizes

Process	Unit	Diameter (mm)	1.0	1.2	2.0	2.4	3.2
GTAW	2 and 10 kg tube				X	X	X
GMAW	15 kg spool BS300		X	X			

Other sizes and packaging on request

LNT/LNM NiCro 70/19: rev. EN 20