

ROYAL ER NiCrCoMo1 (ER NiCrCoMo1)

AWS –SFA A 5.14 ER NiCrCoMo1

Applications

It is used for high temperature application such as heat exchanger, furnace component, gas turbine parts and pipe lines; where good stability , high creep strength and resistance to oxidation, pitting and stress corrosion cracking is required.

Characteristics on Usage

Royal ER NiCrCoMo1 is a solid filler wire to weld Nickel chromium molybdenum base material and joining of various dissimilar high temperature alloys. The weld metal gives excellent strength and oxidation resistance above 820 up to 150°C

Packing

Each packet contents 5 kg. of wire Rods. Special packing will be supply on request.

Shielding Gas

Ar, Ar + He

MIG TIG WIRES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	Cr %	Ni %	Mo%	Co %
0.05-0.15	1.0 Max	1.0 Max	20.0-24.0	Bal.	8.0-10.0	10.0-15.0
Al %	Ti %	S %	P%	Cu %	Fe %	
0.80-1.5	0.60 Max	0.015 Max	0.030 Max	0.50 Max	3.0 Max	

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
620 Min.	20 Min,