

# ES TIG NiCrMo-3

GTAW  
ERNiCrMo-3

**ESWECO**  
*The Art of Welding*

## Description

A nickel-based, corrosion- and heat-resistant, 22% Cr, 9% Mo, 3.5% Nb rod for the GTAW of high-alloyed steel, heat-resistant steel, corrosion-resistant steel, 9% Ni steels and similar steel with high notch toughness at low temperatures. It is also suitable for joining dissimilar metals of the types mentioned above. ES TIG NiCrMo-3 is normally welded with pure Ar as the shielding gas.

## Current

DC (-)

## Classifications

SFA/AWS A5.14	ERNiCrMo-3
EN ISO 18274	S Ni 6625 (NiCr22Mo9Nb)

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu	Al	Fe	Ti
<0.1	<0.5	<0.5	21.5	>60.0	9.0	<0.5	<0.4	<2.0	0.2

## Typical mech. Properties all weld metal

Yield stress, MPa	500
Tensile strength, MPa	780
Elongation, %	40

## Charpy V

Test temps, °C	Impact values, J
+20	130
-105	120
-196	110

## Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0