

ES MIG NiCr-3

GMAW
ERNiCr-3

ESWECO
The Art of Welding

Description

ES MIG NiCr-3 is a nickel-based, corrosion- and heat-resistant, 20% Cr, 3% Mo, 2.5% Nb electrode for the GMAW of high-alloyed steel, heat-resistant steel, corrosion-resistant steel, 9% Ni and similar steels with high notch toughness at low temperatures. It is also suitable for joining dissimilar metals of the type mentioned above.

ES MIG NiCr-3 is usually welded with pure Ar as the shielding gas.

Current

DC+

Classifications

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

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Fe	Ti	Cu
<0.1	<0.5	3.0	20.0	>67.0	<3.0	<0.7	<0.5

Typical mech. Properties all weld metal

Yield stress, MPa	440
Tensile strength, MPa	670
Elongation, %	40

Charpy V

Test temps, °C	Impact values, J
+20	150
-196	100

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V
0.8	5-18	70-190	20-27
1.0	6-13	100-200	21-27
1.2	6-10	160-280	24-30
1.6	4-8	200-350	25-32