RECORD NiCrW 412

DESCRIPTION

- Basic agglomerated flux for SAW of Ni-alloys in joining and overlay applications.
- Also suitable for cryogenic applications : 5% Ni-steel with our Executive 82 wire and 9% Ni-steel with Executive 625 wire.

APPROVALS

Wire	BV	DNV	GL	TUV
Executive 82	--	--	5637	--
Executive 625	UP	YM	UP-NiCr21 Mo9Nb-MR	RWTUV-60

GENERAL CHARACTERISTICS

• Current / Intensity	DC (+ and -) and AC - 800 A max.
• Basicity index	2.1 (according to Boniszewski)
• Granulometry	0.4 - 1.4 mm (14 x 40 Mesh ASTM)
• Apparent density	1
• Consumption	1 (kg fused flux / kg wire)
• Redrying	1 to 2 hours at 350 +/- 50° C

TYPICAL ANALYSIS OF WIRE AND WIRE/FLUX COMBINATION (%)

	ASME 5.9	DIN 1736	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	Ti
Executive 625	ERNiCrMo-3	UP-NiCr21Mo9Nb	0.01	0.12	0.07	22.0	bal.	9.0	3.6	0.4	0.20
All-weld met.			0.01	2.10	0.35	21.5	bal.	8.5	3.3	0.4	0.10
Executive 82	ERNiCr-3	UP-NiCr20Nb	0.01	3.3	0.10	20.5	bal.	--	2.4	0.8	0.35
All-weld met.			0.01	5.0	0.45	20.0	bal.	--	2.1	0.8	0.10

ALL-WELD METAL TYPICAL MECHANICAL PROPERTIES

Wire	Rm[MPa]	Rp0.2[MPa]	A5[%]	Av[ISO - V]
Executive 625	730	460	40	70 J : -- 196° C
Executive 82	600	350	40	90 J : -- 196° C

PACKING

25 kg (pail)

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(following)

SUITABLE FOR

Alloy	UNS	DIN	Wires W. - Nr.	Executive 82	Executive 625
600	N06600	NiCr15 Fe	2.4640	x	x
601	N06601	NiCr23 Fe	2.4851	x	x
800	N08800	X10 NiCrAlTi32 20	1.4876	x	x
800H	N08810	X10 NiCrAlTi32 20	1.4958	x	x
75	N06075	NiCr20 Ti	2.4951	x	x
80A	N07080	NiCr20 TiAl	2.4952	x	x
90	N07090	NiCr20 Co18 Ti	2.4969	x	x
3% Ni	K81340	X8 Ni9	1.5662	x	x
625	N06625	NiCr 22 Mo9 Nb	2.4856	-	x
825	N08825	NiCr 21 Mo	2.4858	-	x
59	N06059	NiCr23 Mo 16Al	2.4605	-	-
C4	N06455	NiMo16 Cr15 Ti	2.4610	-	-
C22	N06022	NiCr 21 Mo14 W	2.4602	-	-
C276	N10276	NiMo16 Cr15 W	2.4819	-	-
-	-	NiCr 20 Mo15	2.4811	-	-