

RECORD NiCrW 412

DESCRIPTION

- Basic agglomerated flux for SAW of Ni-alloys.
- Also suitable for cryogenic applications : 5% Ni-steel with Soudor NiCr 3 wire and 9% Ni-steel with Soudor 625 wire.

APPROVALS

Wire	BV	DNV	GL	TUV
Soudor NiCr 3	--	--	5637	--
Soudor 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
Soudor 625 All-weld met.	ERNiCrMo-3	UP-NiCr21Mo9Nb	0.01 0.01	0.12 2.10	0.07 0.35	22.0 21.5	bal. bal.	9.0 8.5	3.6 3.3	0.4 0.4	0.20 0.10
Soudor NiCr 3 All-weld met.	ERNiCr-3	UP-NiCr20Nb	0.01 0.01	3.3 5.0	0.10 0.45	20.5 20.0	bal. bal.	-- --	2.4 2.1	0.8 0.8	0.35 0.10

ALL-WELD METAL TYPICAL MECHANICAL PROPERTIES

Wire	Rm[MPa]	Rp0.2[MPa]	A5[%]	Av[ISO - V]
Soudor 625	730	460	40	70 J : -- 196° C
Soudor NiCr 3	600	350	40	90 J : -- 196° C

PACKING

25 kg (pail)

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(following)

SUITABLE FOR

Alloy	UNS	DIN	Wires	Soudor NiCr 3	Soudor 625
			W. - Nr.		
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	-	x
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	-	-