

Meltolit

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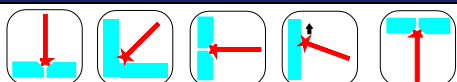
EN ISO 18274: Ni 6054 (NiCr29Fe9)
ASME SFA A5.14: ENiCrFe-7A (UNS N06054)

DESCRIPTION

Nickel-based filler metal characterized by a high chromium level, which provides excellent resistance to stress corrosion cracking. Welds made with this composition are even particularly resistant to ductility-dip-cracking (DDC), and oxide inclusions, mainly due to the increased niobium and to the presence of boron and zirconium.

This grade is used for welding of Inconel 690, overlay of carbon and stainless steels to get corrosion resistant coatings and where resistance to oxidizing acids is required. Typically used in Nuclear power industries and for power boilers.

WELDING POSITIONS



CURRENT

MIG: DC+
TIG: DC-

SHIELDING GAS

MIG: M12, I3
TIG: I1, I3

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(J)</i>
>590* *reference value		30	

WELD METAL COMPOSITION(%)

C	Mn	Si	Ni	Cr	Nb	Fe
<0,04	<1,0	<0,5	rest	28-31,5	0,5-1,0	7,0-11,0
Ti	Al	Nb	B	Zr		
<1,0	<1,1	0,5-1,0	<0,005	<0,02		

PACKAGING & WELDING PARAMETERS

Dimension MIG (mm)	1,0	1,2		
Spool (kg)	15	15		
Dimension TIG (mm)	1,6x1000	2,0x1000	2,4x1000	3,2x1000
Box (kg)	5	5	5	5