

Exaton NiFeCr-1

NiFeCr-1 welding wire is suitable for overlay welding when a deposit with chemistry corresponding to UNS N08825 is required. The weld deposit is a nickel-iron-chromium-molybdenum-copper alloy suitable for use in extremely corrosive environments.

NiFeCr-1 has very good resistance to stress corrosion cracking (SCC) in chloride containing environments and is particularly suited for use in reducing environments such as those containing sulphuric and phosphoric acids.

NiFeCr-1 is used for corrosion resistant alloy surfacing of components in the chemical, pollution control, oil & gas and petrochemical industries and often in connection with sour gas service. Typical components are tanks, heat exchangers, evaporators, transport pipes and scrubbers etc. It is used for MIG/MAG welding.

Classifications Wire Electrode	SFA/AWS A5.14 : ERNiFeCr-1 EN ISO 18274 : S Ni 8065 (NiFe30Cr21Mo3)
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Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Fe
<=0.025	1	<=0.3	<=0.010	<=0.025	>=42.0	23	3	2.3	>=22.0

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
1.0 mm (0.040 in.)	60-220 A	15-28 V	4.0-12.0 m/min (157-472 in./min)
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)
1.6 mm (1/16 in.)	230-350 A	25-30 V	3.0-5.0 m/min (118-197 in./min)