

LNM NiCro 70/19

CLASSIFICATION

AWS A5.14	ERNiCr-3	A-Nr	-	Mat-Nr	2.4806
ISO 18274	S Ni 6082 (NiCr20Mn3Nb)	F-Nr	43		
		9606 FM	6		

GENERAL DESCRIPTION

Solid wire for welding nickel based alloys, dissimilar metals and cladding
High resistance to oxidation and high impact toughness at low temperature

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

SHIELDING GASES (ACC. ISO 14175)

I1	Inert gas Ar (100%)
I3	Inert gas Ar+ 0.5-95% He

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cr	Nb	Cu	Fe
0.03	3.1	0.08	72.5	20.5	2.6	0.01	0.8

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength	Tensile strength	Elongation	Impact ISO-V(J)	
			[N/mm ²]	[N/mm ²]	[%]	+20°C	-196°C
Typical values	I1	AW	390	640	35	150	50

EXAMPLES OF MATERIALS TO BE WELDED

Ni-alloy grades	BS3076	DIN 17744/17465	Mat. Nr	ASTM/ACI	UNS
		SEW 595		B366	
Ni-base high Cr alloy steel for low and high corrosion searching application					
	Na 14	NiCr15Fe	2.4816	B168-Alloy 600	N06600
		LC-NiCr15Fe	2.4817	Alloy 600L	N06600
		NiCr20Ti	2.4951	Alloy 75	
		NiCr20TiA1	2.4952	Alloy 80A	N07080
	Na 15	X10NiCrAlTi32-20	1.4876	Alloy 800/800H	N0800/10
		NiCr23Fe	2.4851	Alloy 601(H)	N06601
	Na 17	X12NiCrSi36-16	1.4864	330	N08330
		G-X40NiCrNb35-25	1.4852		
		G-X40NiCrSi35-25	1.4857	HP	

Un- and low alloy heat and creep resistant steel to stainless steel

APPLICATION ADVICE

Limit heat-input (HI<1.5kJ/mm) and interpass temperature (Ti<150°C)

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2
15 kg spool BS300	X	X
Other sizes and packaging on request		

LNM NiCro 70/19: rev. C-EN23-01/02/16

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.
Fumes: Material Safety Data Sheets (MSDS) are available on our website.

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