

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

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	3.0	0.2	bal.	20	2.5	0.1	1.0

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical values	Shielding gas	Condition	0.2% proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						+20°C	-196°C
	I1	AW	400	680	40	150	120

EXAMPLES OF MATERIALS TO BE WELDED

Ni-alloy grades	BS3076	DIN 17744/17465 SEW 595	Mat. Nr	ASTM/ACI B366	UNS
Ni-base high Cr alloyed 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)	2.0	2.4	3.2
2.5 kg PE-Tube	X	X	X

Note : Cut length = 1000 mm

LNT NiCr 70/19: rev. C-EN24-01/02/16