

Applications

It is used for welding of Nickel, chromium & molybdenum alloy ASTM B443, B444 & B446 steel with other Nickel base alloys for cladding steel with Ni-Cr-Mo weld metal This filler metal is recommended for application where the operating temp. ranges from cryogenic to 1000 F (540 o C)

Characteristics on Usage

Royal ER NiCrMo3 – Nickel alloys solid filler Wire Rods deposit 61% Ni, 22% Cr, 9% Mo, 3.5 % Nb+ Ta This type of filler wire rod is used for welding of Nickel Chromium & Molybdenum alloys steel for surfacing steel with nickel chromium molybdenum weld metal.

Chemical Composition Of Weld Metal

| C% | Mn% | Si% | S% | P% | Cr % | Ni % | Mo |
|----------|----------|----------|-----------|-----------|-------------|--------|-------|
| 0.10 Max | 0.50 Max | 0.50 Max | 0.015 Max | 0.020 Max | 20.0 – 23.0 | 58 Min | 8.0 - |

Mechanical Properties Of Weld Metal

| U.T.S. (N/mm ²) | ELONGATION (L = 4d) % |
|--------------------------------|----------------------------|
| 760 Min. | 30 Min, |

Approvals

B.V.

Packing

Each packet contents 5 kg. of wire Rods. Special packing will be supply on request.