Exaton Ni60 (GTAW)

Exaton Ni60 welding wire is suitable for joining nickel-chromium-molybdenum nickel alloys and chromiumnickel-molybdenum steels with very high corrosion resistance in oxidizing, aqueous and high temperature environments such as 6Mo-steels, UNS N06625 (2.4856) and corresponding grades. It is also suitable for joining stainless steels and nickel alloys for high-temperature service. Exaton Ni60 can also be used for dissimilar joining of stainless steels to nickel alloys, for overlay welding and is available as both wire and rod. Applications for Exaton Ni60 are found in cryogenics, components subject to high temperature service up to 980°C (1800°F) such as aircraft ducting, engine exhaust systems, power boilers and recovery boilers and a diversity of seawater applications. The combination of strength and corrosion resistance over a wide range of temperatures is utilized in reaction vessels, line pipe distillation columns and heat exchangers.

Specifications	
Classifications	SFA/AWS A5.14 : ERNiCrMo-3 EN ISO 18274 : S Ni 6625 (NiCr22Mo9Nb) Werkstoffnummer : 2.4831
Approvals	BV : ERNiCrMo-3 VdTÜV : 19478

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Alloyed nickel (Ni + 22 % Cr + 9 % Mo - 3.5 % Nb)
Shielding Gas	I1, I3, R1 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	540 MPa	780 MPa	47 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
As Welded	20 °C	170 J
As Welded	-46 °C	150 J
As Welded	-196 °C	140 J

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Al**	**Cu**
0.01	0.03	0.06	0.001	0.003	64	21.9	8.7	0.1	0.01

Typical Weld Metal Analysis %			
Ti	**Co**	**Fe**	**Nb+Ta**
0.2	0.02	1.1	3.50

Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Al**	**Cu**
0.015	0.02	0.05	0.001	0.002	65	22	8.9	0.1	0.01

Typical Wire Composition %					
N	**Nb**	**Ti**	**Co**	**Fe**	**Nb+Ta**
0.02	3.4	0.2	0.01	0.3	3.5