

LNT NiCro 60/20

CLASSIFICATION

AWS A5.14/A5.14M - ERNiCrMo-3
ISO 18274 - S Ni 6625 (NiCr22Mo9Nb)

GENERAL DESCRIPTION

Solid rod for welding of nickel alloys
Extreme resistance to various corrosion forms
High chromium and molybdenum content

SHIELDING GASES (ACC. ISO 14175)

11 Inert gas Ar (100%)
13 Inert gas Ar+ 0.5-95% He

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cr	Mo	Nb	Fe
0.03	0.1	0.1	bal.	22	9	3.5	0.4

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						+20°C	-196°C
Typical values	11	AW	520	800	35	130	100

MATERIALS TO BE WELDED

Ni-alloy grades	DIN/EN	Mat. Nr	ASTM/ACI	UNS
NiCrMo-steel type alloy 625 and welding dissimilar high NiCrMo-steels for corrosion and heat resisting purposes				
	X1NiCrMoCuN25-20-6	1.4529	Alloy 925	N08925
	X1NiCrMoCu25-20-5	1.4539	Alloy 904L	N08904
	X1CrNiMoCuN20-18-7	1.4547	Alloy 254	S31254
	X2NiCrAlTi32-20	1.4558	Alloy 800L	N08800
	G-X10NiCrNb32-20	1.4859		
	X10NiCrAlTi32-20	1.4876	Alloy 800/800H	N08800/-10
	NiCr22Mo6Cu	2.4618	Alloy G	N06007
	NiCr22Mo7Cu	2.4619	Alloy G-3	N06985
	NiCr21Mo6Cu	2.4641	Alloy 825hMo	N08821
	NiCr20CuMo	2.4660	Alloy 20	N08020
	NiCr15Fe	2.4816	B168-Alloy 600	N06600
	NiCr22Mo9Nb	2.4856	B443-Alloy 625	N06625
	NiCr21Mo	2.4858	B424-Alloy 825	N08825
	NiCr20Ti	2.4951	Alloy 75	N06075
	NiCr20TiAl	2.4952	Alloy 80A	N07080
Low alloyed steels	10Ni14 (3.5% Ni)	1.5637	ASTM A333 Grade 3	-
	12Ni19, X12Ni5	1.5680	-	K41583
9% Ni-steel for LNG storage tanks	X8Ni9	1.5662	A353/A353M	-
	X8Ni9 / 8%Ni	1.5662	A553/A553M Type I/II	- / K71340

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.0	2.4	3.2	
Unit : 2 & 10 kg tube	X	X	X	X	Note : Cut length = 1000 mm
Other sizes and packaging on request					

LNT NiCro 60/20: rev. EN 22

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Fumes: Material Safety Data Sheets (MSDS) are available on our website.