

62-50

TIG (GTAW)

SOLID WIRE FOR TIG

PRODUCT DESCRIPTION

Solid rod for TIG

CLASSIFICATIONS

AWS A5.14M ERNiCrMo-3
 ISO 18274 S Ni 6625
 APPROVALS DNV, TÜV

ASME IX QUALIFICATION

QW432 F-No 43

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Nb	Cu	Al	Ti	Fe
Min.	--	--	--	--	--	20.0	60.0	8.0	3.15	--	--	--	--
Max.	0.05	0.50	0.50	0.015	0.015	23.0	bal	10.0	4.15	0.50	0.40	0.40	1.0
Typical	0.015	0.02	0.05	0.004	0.004	22	65	9	3.5	0.05	0.2	0.2	0.2

ALL-WELD MECHANICAL PROPERTIES

Typical values as welded		RT	165°C
Tensile strength (MPa)		775	710
0.2% proof strength (MPa)		500	440
Elongation (%)	4d	42	42
	5d	40	40
Reduction of area (%)		55	--
Impact ISO-V(I) -196°C		140	--
Hardness cap/mid (HV)		205/225	--

Cannot meet TS > 827MPa required by cold rolled ASTM N06625 Grade 1, but meets PS > 414MPa and properties of hot rolled grades.
 Cast CW-6MNC solution annealed 1175°C + WQ requires TS > 485MPa.

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon	DC-	2.4	100A, 12V

Also required as a purge for root runs.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	2.5	PE TUBE	T6250-16
2.0	2.5	PE TUBE	T6250-20
2.4	2.5	PE TUBE	T6250-24
3.2	2.5	PE TUBE	T6250-32