

62-50

SAW

SOLID WIRE FOR SAW

PRODUCT DESCRIPTION

Solid wire for sub-arc welding.

CLASSIFICATIONS

AWS A5.14M ERNiCrMo-3
ISO 18274 S Ni 6625

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	SAW + NiCr	SAW +P2007
Tensile strength (MPa)	725	780
0.2% proof strength (MPa)	490	520
Elongation (%) 4d	45	45
5d	42	42
Reduction of area (%)	50	50
Impact ISO-V(J) -196°C	100	100
Hardness cap/mid (HV)	235/255	235/255

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

TYPICAL OPERATING PARAMETERS

Flux	Current	Diameter (mm)	Parameters
NiCr flux	DC+	1.6	300A, 26V

Also required as a purge for root runs.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	25	B415	SA6250-16
2.4	25	B415	SA6250-24