

62-50

MIG (GMAW)

SOLID WIRE FOR MIG

PRODUCT DESCRIPTION

Solid wire for MIG welding.

CLASSIFICATIONS

AWS A5.14M ERNiCrMo-3
ISO 18274 S Ni 6625
APPROVALS 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
Tensile strength (MPa)	750
0.2% proof strength (MPa)	490
Elongation (%) 4d	42
5d	40
Impact ISO-V(I) -196°C	120
Hardness cap/mid (HV)	220/240

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

Shielding gas	Current	Diameter (mm)	Parameters
Argon or ArHe	Pulsed	1.2	130A, 29V (mean)

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
0.8	15	S300	M6250-08
1.0	5	S200	M6250MD-10
1.0	15	S300	M6250-10
1.2	15	S300	M6250-12

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr ³	Ni	Mo	Cu	OES (mg/m ³)
1	1	17	50	9	< 0.5	1