

NiCrMo4

Comparable specifications

ASME SFA A 5.14: ERNiCrMo-4
EN ISO 18274: Ni 6276 - NiCr15Mo16Fe6W4
BS 2901: Pt 5 NA 48
Werkstoff Nr.: 2.4886

Description and applications*

* *Illustrative, not-exhaustive list*

This grade may be used for:

- welding of low carbon nickel-chromium-molybdenum alloys;
- welding of the clad side in steel clad with low carbon nickel-chromium-molybdenum alloy;
- welding of low carbon nickel-chromium-molybdenum alloys to steel and other nickel-base alloys;
- joining and surfacing of alloys of a similar composition;
- joining of these alloys to steel and other nickel alloys;
- applications in the chemical process industry, in the paper industry, and within pollution control equipments;
- use in high-grade plant/engineering (primarily for the petro-chemical industry).

Weldable base materials*

* *Illustrative, not-exhaustive list*

Hastelloy C-276

All-weld metal mech. properties*

* *For reference only values*

Tensile strength (Rm): $\geq 690 \text{ N/mm}^2$

Chemical composition*

* *For reference only values*

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Cr	Mo	V	W
max	max	4.00	max	max	max	max	50.00	max	14.50	15.00	max	3.00
0.020	1.00	7.00	0.020	0.015	0.08	0.50	min	2.50	16.50	17.00	0.30	4.50

Standard packaging data*

Welding process	Product type	Ø mm (inches)	Packing type	Weight kg (lbs)	Length mm (inches)
GMAW **	filler wire	0.80 - 1.20 (0.030 - 0.047)	spools BS300 / D300	15 (33)	n.a.
GTAW **	filler rod	1.60 - 4.00 (1/16 - 5/32)	cardboard boxes / tubes	5 (11)	1000 (39.4)

* *Other sizes and packing types are available upon request*

** *GMAW: gas metal arc welding; GTAW: gas tungsten arc welding*

Marking

Each filler rod for GTAW welding is durably marked with an identification traceable to the unique product type. Welding filler materials wound on spools or in coils are durably marked on the coil or spool with an identification traceable to the unique product type.

The outside of each unit package is suitably labelled with at minimum the following data: grade, diameter, heat, lot no., classifications.

Customized labels are available upon request.

Lot classification

All our productions fulfil the **Class S3** requirements acc. to EN ISO 14344.