

NiFeCr1

Comparable specifications

ASME SFA A 5.14: ERNiFeCr-1
EN ISO 18274: Ni 8065 - NiFe30Cr21Mo3
Werkstoff Nr.: 2.4858

Description and applications*

* *Illustrative, not-exhaustive list*

Nickel-iron-chromium alloy which provides great resistance to corrosive environments, to reducing environments, to stress-corrosion cracking, to pitting corrosion and to oxidizing substances.

This grade may be used for (e.g.):

- welding of copper alloyed chromium-nickel-molybdenum alloys and nickel-iron-chromium molybdenum alloys;
- surfacing of steel;
- applications in severe corrosive environments, such as sea water, oil related industries and solutions of sulfuric acid or phosphoric acid;
- applications in chemical industry, pollution control or pickling systems.

Weldable base materials*

* *Illustrative, not-exhaustive list*

UNS N08904, UNS N08825

All-weld metal mech. properties*

* *For reference only values*

Tensile strength (Rm): ≥ 550 N/mm²

Chemical composition*

* *For reference only values*

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Ti	Cr	Mo
max	0.70	22.00	max	max	max	2.30	43.00	max	1.00	22.00	3.00
0.05	0.90	min	0.020	0.004	0.50	3.00	46.00	0.20	1.20	23.50	3.50

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.