FCW NI96

All positions flux cored wire
For 9% Ni steel welding

Classification

AWS A5.34 : ~ENiCrMo6T1-4 ISO 12153 : T Z Ni 6620 (NiCr14Mo7Fe) P M21 1

Description & Applications

Flux cored nickel base wire for gas shielded (Ar + CO_2) arc welding in all positions of 9% nickel alloys. Used to weld low alloy steels for cryogenic applications. Linear expansion equivalent to that of 9% Ni steels.

Main applications: Cryogenic applications...

Base materials

UNS	Alliage	EN	Mat. N°
K81340	9% Ni steel	X8Ni9	1.5662
K41583	5% Ni steel	X12Ni5	1.5680
	3.5% Ni steel	10Ni14 or	1.5637

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Fe	Nb	W	P	S	Ni
0.01	0.40	2.5	16.0	6.0	2.0	2.0	1.5	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
470	720	40	-196°C	100

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	130 - 220	24 - 32	12 - 25	ISO 14175 : M21 (Ar + CO_2) 10-20 l/min

FT-En-CI08-180212