



Selectarc FCW Ni645

Classification

AWS A5.21 : ERCNiCr-B

EN 14700 : T Ni3

Description

Metal-Cored Wire for gas shielded metal arc overlay. Nickel-based alloy containing Chromium, Silicon and Boron. Smooth bead and excellent weld metal appearance. Low melting point of the alloy enables to achieve low dilution levels. Excellent resistance to Galling, Wear, Friction and Corrosion with moderate impact. Low coefficient of metal to metal friction. Hot Hardness maintained up to 650°C and oxidation resistant up to 950°C. Metal recovery can be achieved up to 95-98%.

Applications

Wire used for overlay of valve parts and seals, Pump parts, Drawing dies, Extruder and Conveyor screws, Glass and Brick moulds, Mixer parts.

Typical Weld Metal Composition (%)

C	Mn	Si	Cr	B	Fe	Ni
0.55	0.18	3.80	11.70	2.40	3.30	Bal.

All Weld Metal Mechanical Properties

Hardness 3rd layer (AW)
48-52 HRc

Operating Instructions

Polarity	Wire Ø (mm)	Current (A)	Voltage (V)	Stick-out (mm)	Gas/ Gas flow rate (lts./min)
DC (+)	1.20	95 – 240	15 – 28	14 – 28	ISO 14175 : I1 (Argon) 12-20
	1.60	130 – 340	15 – 30	16 – 30	

Welding Positions

Flat, half up, half down

Packing & Storage

15 kg (BS300) Spool packed in Corrugated Cardboard Boxes. Wire to be Stored in dry conditions.

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