



A₅ 'NI65

Classification

ISO 18274 : S-Ni 8065 (NiFe30Cr21Mo3) Material N° : 2.4858
 AWS A5.14 : ERNiFeCr-1

Description & Applications

Solid wire used to weld Nickel-Iron-Chromium alloys which have a good resistance to oxidizing and reducing acids like sulphuric and phosphoric acid as well as sea water.

Base material:	UNS	Alloy	DIN	Material N°
	N08825	Alloy 825	NiCr21Mo	2.4858

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe	Cu	Ti	P	S
0.02	0.2	0.6	20.5	41.0	3.2	30.0	1.8	0.9	<0.01	<0.01

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
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Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	80-140	23-27	Ar Ar + He Ar/He + 0.05% CO ₂ 18-20 l/min
	1.0	90-160	24-28	
	1.2	160-200	24-28	
	1.6	180-260	24-28	

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