



A₅ 'NI718

Classification

ISO 18274 : S-Ni 7718 (NiFe19Cr19Nb5Mo3) Material N° : 2.4667
 AWS A5.14 : ERNiFeCr-2 AMS : 5832

Description & Applications

Solid wire for GMAW of similar alloys like INCONEL* 718, X 750 and 706. Excellent resistance against thermal shocks and oxidation. Used for structural hardening, for high mechanical resistance up to 700°C. Could be used for hardfacing of hot working tools.

* Trademark of Inco Alloys

Typical Chemical Composition (%)

| C | Si | Mn | Cr | Mo | Fe | Nb | Al | Ti | Ni |
|------|-----|-----|------|-----|------|-----|-----|-----|------|
| 0.04 | 0.2 | 0.2 | 19.0 | 3.0 | Rem. | 5.0 | 0.5 | 0.9 | 52.0 |

All Weld Metal Mechanical Properties

| R _{p0.2} (MPa) | R _m (MPa) | A ₅ (%) | KV (J) |
|---------------------------|------------------------|----------------------|--|
| >900 | >1200 | >8 | 240 HB as welded ~45 HRC after PWHT |

Welding Current & Instructions

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

Ind.10



Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.