



# MIG NI59

Old reference: MIG Ni059

## Classification

ISO 18274 : S-Ni Z (NiCr25Mo15)  
 AWS A5.14 : ~ERNiCrMo-13

Material N° : ~2.4607

## Description & Applications

Nickel alloy with high content of Cr and Mo, which gives it an exceptional corrosion resistance. It is particularly recommended for cladding of carbon steels and for welding of C 276, C 22, alloy 59, other highly corrosion resistant Ni-alloys and special stainless steels.

**Main applications:** Works well in different environments, de-pollution (absorbers, chimneys), sea water and fertiliser, flue gas desulphurisation.

### Base material:

UNS	Alloy	DIN	Material N°
N06059	59	NiCr23Mo16Al	2.4605
N06022	C-22	NiCr21Mo14W	2.4602
N10276	C-276	NiMo16Cr15W	2.4819
N06455	C-4	NiMo16Cr16Ti	2.4610
N06625	625	NiCr22Mo9Nb	2.4856
N08825	825	NiCr21Mo	2.4858
N08926	254SMo	X1NiCrMoCuN25 20 6	1.4529

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Mo	Fe	Al	P	S	Ni
0.01	0.05	0.1	25.0	15.0	0.2	0.1	<0.01	<0.01	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
420	740	30

## 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 <sub>2</sub> 18-20 l/min
	1.0	90-160	24-28	
	1.2	160-200	24-28	
	1.6	180-260	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.