



TIG NI65

Old reference: TIG Ni65

Classification

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

Description & Applications

Solid rod for TIG welding of Nickel-Iron-Chromium-Molybden alloys which has a good resistance to oxidizing and reducing acids like sulphuric and phosphoric acid as well as sea water.

Base materials: Alloy 825, UNS N08825, NiCr21Mo, 2.4858.

Typical Chemical Composition (%)

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

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
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Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon : 3-6 l/min

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