



TIG NI686

Classification

AWS A5.14 : ERNiCrMo-14

Description & Applications

Nickel alloy for TIG welding of UNS N06686 and similar compositions. Could be used for overmatching such as C-276 alloy.

Main applications: Overlay on carbon and low alloys steels

Typical Chemical Composition (%)

| C | Si | Mn | Cr | Mo | Fe | W | Ti | W | Al | P | S | Other | Ni |
|--------|--------|-----|------|------|-----|-----|-------|-----|------|-------|-------|-------|------|
| < 0.01 | < 0.08 | 0.1 | 21.0 | 16.0 | 0.2 | 3.7 | <0.25 | 3.7 | <0.5 | <0.02 | <0.02 | < 0.5 | Rem. |

All Weld Metal Mechanical Properties

| $R_{p0.2}$ (MPa) | R_m (MPa) | A_5 (%) |
|--------------------|---------------|-------------|
| - | 760 | 30 |

Welding Current & Instructions

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

FT Txxxx-1408

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