



TIG NIW

Old reference: TIG NiW

Classification

ISO 18274 : S-Ni 1004 (NiMo25Cr5Fe5) AMS : 5786
AWS A5.14 : ERNiMo-3

Description & Applications

Solid rod for TIG welding of dissimilar alloys known as HASTELLOY W®.

Used in the aeronautical industry for reparation and maintenance of engines.

® Trade mark of Haynes alloys

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Fe	W	P	S	Ni
0.03	0.2	0.4	5.0	24.0	6.0	0.03	<0.01	<0.01	Rem.

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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