

MIDALLOY ERNiCrMo-3 (FM 625) BARE WIRE

CLASSIFICATION

- AWS 5.14 Class ERNiCrMo-3 / ASME SFA 5.14 Class ERNiCrMo-3

DESCRIPTION

- MIDALLOY ERNiCrMo-3 nickel alloy bare wire is used for GMAW, GTAW, and SAW welding.

APPLICATIONS

- MIDALLOY ERNiCrMo-3 is used for joining base materials such as UNS number N06625 and UNS number N08825. This includes ASTM grades such as B443, B444, B446, B564, B704, B705, B751, B163, B423, B424, and B425.
- This alloy can also be used for dissimilar welding using various nickel-chromium-molybdenum alloys and stainless steel, low alloy, and even carbon steels.
- MIDALLOY ERNiCrMo-3 is formulated with low iron (less than 1.0%), and high chromium (over 21.5%) to be an excellent choice for overlaying tubes and tube panels where low dilution of iron and high deposits of chromium are required.
- This alloy offers resistance to stress corrosion cracking, pitting, and crevice corrosion.

TYPICAL CHEMISTRY

C	Mn	Si	Fe	Mo	Cr
.02	.05	.02	.50	9.0	22.0
Ni	Cb + Ta	Ti	Al	S	P
64.5	3.5	.20	.20	.002	.005

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	114,000 PSI
YIELD STRENGTH	85,000 PSI
ELONGATION	38%

RECOMMENDED WELDING PARAMETERS

(See Attached)

STANDARD PACKAGING

- TIG 10 lb. tube / 60 lb. carton
- MIG 30 lb. spool
- SUB-ARC 60 lb. coil

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