

MIDALLOY MASTERCOR ENiCrFe-2FC AP FLUX-CORED WIRE

CLASSIFICATION

- Chemistry conforms to AWS/SFA 5.34. The AWS classification for this flux-cored wire is class ENiCrFe-2T1-4 for Argon-CO₂ shielding gas and ENiCrFe-2T1-1 for 100% CO₂ a shielding gas.

DESCRIPTION

- MIDALLOY MASTERCOR ENiCrFe-2 flux-cored wire is an all position nickel base alloy formulated for maximum welder appeal, with an excellent bead appearance.
- UNS# W86133
- ISO# TNi6133-xy
- This wire offers improved wetout, optimal slag removal, and an x-ray quality weld.
- This combination provides an easy adaptation to automatic and semi-automatic applications, resulting in increased productivity over conventional shielded metal arc welding electrodes and solid wires.

APPLICATIONS

- MASTERCOR ENiCrFe-2 is used for joining nickel-chromium-iron alloys, 9% nickel steel, and a variety of dissimilar metal combinations including: carbon steel, stainless steel, and nickel alloys.
- This product maintains strength and oxidation resistance at service temperatures from cryogenic to 1500°F.

PROCEDURE

- Keep preheat and postheat to a minimum or according to base material.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Cb + Ta
0.02	14.4	Bal.	2.0	2.4	0.33	.01	.01	0.02	2.2

MECHANICAL PROPERTIES

TENSILE STRENGTH	80,000 PSI Min.
ELONGATION	30% Min.

WELDING PARAMETERS

SIZE	VOLTS	AMPS	STICKOUT	SHIELDING GAS
.045"	24-28	120-200	1/2"	CO ₂ or Ar/CO ₂ mix
1/16"	22-28	150-250	3/4"	CO ₂ or Ar/CO ₂ mix
3/32"	23-28	300-400	3/4"	CO ₂ or Ar/CO ₂ mix

STANDARD PACKAGING

- 33 lb. spool

12-1-08

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