

MIDALLOY MASTERCOR ENiCrMo-10 AP FLUX-CORED WIRE

CLASSIFICATION

- Chemistry conforms to AWS/SFA 5.34. The AWS classification for this flux-cored wire is class ENiCrMo-10T1-4 for Argon CO₂ shielding gas and ENiCrMo-10T1-1 for 100% CO₂ shielding gas.

DESCRIPTION

- MIDALLOY MASTERCOR ENiCrMo-10 is a flux-cored nickel alloy welding wire designed for all position welding.
- UNS# W86022
- ISO# TNi6022-xy
- This wire offers excellent arc stability with little spatter and easy slag removal.

APPLICATIONS

- Midalloy Mastercor ENiCrMo-10 is used for joining nickel-chromium-molybdenum alloys of similar composition, as well as dissimilar materials such as nickel-chromium-molybdenum alloys to stainless steel or low alloy steels.
- Because of its excellent corrosion resistance in oxidizing as well as reducing media, and its outstanding resistance to stress corrosion cracking, pitting, and crevice corrosion, this alloy is often chosen for cladding.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Co	W	V	Fe	Others
.018	21.0	Bal	13.7	.29	.20	.006	.004	.08	.06	3.14	.02	5.48	<.50

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	106,900 PSI
YIELD STRENGTH	70,325 PSI
ELONGATION	34.5 %

These properties were generated using 75% Argon/25% CO₂. 100% CO₂ values are available upon request.

WELDING PARAMETERS

SIZE	VOLTS	AMPS	STICKOUT	SHIELDING GAS
.045" DIA.	25-28	140-200	1/2"	75 Ar / 25 CO ₂ or 100% CO ₂
1/16" DIA.	26-28	190-230	1/2"	75 Ar / 25 CO ₂ or 100% CO ₂

Note: Must use 75/25 for overhead and vertical. Optimum vertical 140 amps-25 volts.

STANDARD PACKAGING

33 lb. spool

12-1-08

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Office and Corporate Warehouse
 630 Axminister Drive
 Fenton, MO 63026 • 636-349-6000 • 800-776-3300
 Fax 636-349-2240

