MIDALLOY MASTERCOR ENiCrMo-3FC AP FLUX-CORED WIRE

CLASSIFICATION

- Chemistry conforms to AWS/SFA 5.34. The AWS classification for this flux-cored wire is Class ENiCrMo-3T1-4 for Argon-CO_2 shielding gas and ENiCrMo-3T1-1 for 100% CO_2 shielding gas.

DESCRIPTION

- MIDALLOY MASTERCOR ENiCrMo-3FC AP is an all position flux-cored nickel alloy wire with excellent weldability.
- UNS# W86625
- ISO# TNi6625-xy

APPLICATIONS

- MIDALLOY MASTERCOR ENiCrMo-3FC AP is used for joining nickel-molybdenum-chromium alloys.
- This wire is also used for surfacing steel and joining steels to nickel based alloys.
- Power plant field welding and overlay of water wall panels and membrane welding.
- Longitudinal and circumferential welded seams of coal de-sulfuring equipment and stacks.
- Welding super austenitic stainless steels (i.e. 904L, AL6XN, Sanicro 28, 6MO)

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Mo	Fe	Nb	S	P	Ni
0.08	0.2	0.3	22.0	8.5	0.5	3.4	0.003	0.010	Bal

TYPICAL MECHANICAL PROPERTIES*

TENSILE STRENGTH	109,000 PSI
YIELD STRENGTH	72,000 PSI
ELONGATION	30%
CHARPY IMPACT TOUGHNESS @-320°F (52 Joules)	38 ft. lbs.
LATERAL EXPANSION	37 mils

*These properties were generated using 75% Argon – 25% CO_2. 100% CO_2 values are available upon request.

WELDING PARAMETERS

SIZE	VOLTS	AMPS	STICKOUT	SHIELDING GAS
.045”	25-28	140-200	½”	75 Ar/25 CO_2 or 100% CO_2
1/16”	26-28	190-230	½”	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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