MIDALLOY MASTERCOR ENiCrMo-4 AP FLUX-CORED WIRE

CLASSIFICATION

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

DESCRIPTION

- MIDALLOY MASTERCOR ENiCrMo-4 AP is a flux-cored nickel alloy welding wire designed for all position welding.
- This wire offers excellent arc-stability, with little spatter and easy slag removal.
- UNS# W80276
- ISO# TNi6276-xy

APPLICATIONS

- MIDALLOY MASTERCOR ENiCrMo-4 AP flux-cored wire is used for welding nickel-chromium-molybdenum alloys of similar chemistry.
- Overlay welding when nickel-chromium-molybdenum deposit is required.
- Joining higher molybdenum-high nitrogen containing stainless steels.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Co	W	V
.02	15.5	BAL.	15.6	.40	.20	.005	.001	.15	.25	3.8	.05

TYPICAL MECHANICAL PROPERTIES (as deposited)

TENSILE STRENGTH	106,000 PSI
YIELD STRENGTH	68,000 PSI
ELONGATION	42%
CHARPY IMPACT TOUGHNESS @ 320°F (42 Joules)	31 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	STICK-OUT	GAS
Flat .045”	24-30	140-210	½”	75 Ar/25 CO_2 or 100% CO_2
Vertical .045”	24-28	165-185	½”	75 Ar/25 CO_2

STANDARD PACKAGING

- 33 lb. spool

12-1-08

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