

# NST TIG ERNiCrMo-3

AWS A5.14/A5.14M ERNiCrMo-3  
EN ISO 18274:NiCr22Mo9Nb



## Tig-rod for welding of 6Mo alloy (i.e 254 SMO and Inconell 625).

### General description:

NST TIG ERNiCrMo-3 is used for welding of 6Mo alloy (i.e. 254 SMO and Inconell 625) and for cladding of mild steel and other stainless steels. The filler metal is used for manual welding of both pipes and plates. Normally, pure Argon or Argon/Helium mix is used as the shielding gas. Level of gas flow will depend upon TIG-rod diameter and specific application. When welding pure Austenite materials, it is recommended to use very low heat input, low mixture with parent material and low inter-pass temperature.

Each TIG-rod is colour coded in black and has the AWS designation embossed according to the requirements of the NORSOK standard. "Purity" is the keyword when welding high alloyed materials. Impurities in the weld, will cause porosity. Welding of pipes require use of purge gas in order to ensure a stainless root face of the weld. Please contact us for further details on purge equipment. Inter-pass temperature should not exceed 150 °C, and heat input should not exceed 1.5kJ/mm.

### Welding positions:



### Current:

DC-

### Gas flow:

8-20 l/min.

### Chemical composition of welding rod:

C	Mn	Si	P	S	Cu	Ni	Cr	Mo	Fe	Ti	Al	Nb+Ta	
Max 0.10	Max 0.50	Max 0.50	Max 0.02	Max 0.015	Max 0.50	Min 58.0	20.0-23.0	8.0-10.0	Max 0.5	Max 0.40	Max 0.40	3.15-4.15	

### Shielding gas:

Shielding gas: Ar or Ar/He  
Root gas/Purge gas: Ar

### Mechanical properties of all-weld-metal:

Yield and Tensile Strength				
Yield Mpa(Rp0.2)	Tensile Mpa(Rm)	Elongation %		
>565	>785	≥39		

### Ferrite content:

WRC	De Long	Schaeffler	
-	-	-	

### Packaging information:

1,6mm x 500mm x 2,5 Kg  
2,0mm x 500mm x 2,5 Kg  
2,4mm x 500mm x 2,5 Kg

1000mm on special order.

### Approvals:

### Reference / date:

NST TIG ERNiCrMo-3,  
English, 06.10.2016.