MasterWeld
The Welder's Ultimate Choice

TECHNICAL DATA SHEET
NICKEL ALLOY FILLER METAL

NiCrMo3

Comparable specifications

ASME SFA A 5.14: ERNiCrMo-3
EN ISO 18274: Ni 6625 - NiCr22Mo9Nb
BS 2901: Pt 5 NA 43
Werkstoff Nr.: 2.4831

Description and applications*

* *Illustrative, not-exhaustive list*

This grade may be used for:

- welding of nickel-chromium-molybdenum alloys to themselves, to steel a/o to other nickel base alloys;
- cladding of steel with nickel chromium-molybdenum weld metal;
- welding of the clad side of joints in steel with nickel-chromium-molybdenum alloy;
- joining of other nickel alloys where micro-fissuring is problematic;
- applications in the chemical process industry, in marine engineering and within pollution control equipments;
- applications where the operative temperature ranges from cryogenic to 540°C;
- use in high-grade plant/engineering (primarily for the petro-chemical industry).

Weldable base materials*

* *Illustrative, not-exhaustive list*

Inconel 601, Incoloy 800, Alloy 625, Alloy 825, Alloy 926

All-weld metal mech. properties*

* *For reference only values*

Tensile strength (Rm): ≥ 760 N/mm^2
Yield Strength ($Rp_{0.2}$): ≥ 415 N/mm^2
Elongation: ≥ 35%
Charpy-V Impact (R.T.): ≥ 100 J

Chemical composition*

* *For reference only values*

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Al	Ti	Cr	Nb+Ta	Mo
max	max	max	max	max	max	max	60.00	max	max	max	20.00	3.15	8.00
0.10	0.50	5.00	0.015	0.015	0.50	0.50	min	1.00	0.30	0.40	23.00	4.15	10.00