

Exaton NiCrMo-14

NiCrMo-14 is a nickel-chrome-molybdenum alloy of type alloy 686 and is the highest alloyed of all Ni-Cr-Mo alloys. NiCrMo-14 is used for joining nickel alloy such as UNS N06022 (2.4602), UNS N06059 (2.4605), UNS N10276 (2.4819) and super duplex.

The material is thermally unstable at temperatures above 1200°C (2192°F) resulting in great risk for intermetallic phases after welding.

NiCrMo-14 provides the best corrosion resistance in most applications and is particularly useful for weld overlay surfacing of boiler tubes in waste-to-energy boilers. Also, the material can be used in the petrochemical, chemical, oil and gas and marine industries. It is used for MIG/MAG welding.

Classifications Wire Electrode	SFA/AWS A5.14 : ERNiCrMo-14 EN ISO 18274 : S Ni6686 (NiCr21Mo16W4)
Approvals	CE EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	110 J (81 ft-lb)
As Welded	-196 °C (-321 °F)	75 J (56 ft-lb)

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.01	0.4	0.06	0.003	0.02	57	20	16	0.3	0.05

Typical Wire Composition %

Ti	Fe	W
0.1	0.6	3.5

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)