

## Exaton Ni55

Exaton Ni55 is a nickel-chrome-molybdenum alloy of type alloy 686 and is the highest alloyed of all Ni-Cr-Mo alloys. Exaton Ni55 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.

Exaton Ni55 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.

<b>Classifications Wire Electrode</b>	SFA/AWS A5.14 : ERNiCrMo-14 EN ISO 18274 : S Ni6686 (NiCr21Mo16W4)
<b>Approvals</b>	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	110 J
As Welded	-196 °C	75 J

### 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	150-260 A	24-29 V	3.0-10.0 m/min