

Exaton NiCr-3

NiCr-3 is filler material for joining NiCrFe alloys, 9% Ni steels used at cryogenic temperatures, stainless steels to carbon steels, high service temperature NiCu alloys to carbon steels and NiCu alloys to nickel alloys. NiCr-3 can be used in air up to 1175°C (2145°F) and in sulphur dioxide atmospheres up to 800°C (1470°F). It is used for MIG/MAG welding.

Classifications Wire Electrode	SFA/AWS A5.14 : ERNiCr-3 EN ISO 18274 : S Ni 6082 (NiCr20Mn3Nb)
Approvals	CE EN 13479 VdTUV 00073

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

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<0.02	3.2	0.01	0.003	<0.003	73	20	0.01	0.01	0.03

Typical Weld Metal Analysis %

Nb	Ti	Co	Fe	Nb+Ta
2.2	0.4	<0.02	≤1	2.5

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
<=0.03	3	0.1	<=0.01	<=0.01	73	20.0	≤0.05	0.4	<=0.05

Typical Wire Composition %

N	Nb	Ti	Co	Fe	Nb+Ta
<=0.05	2.5	0.4	<=0.1	<=1	2.6

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm (0.030 in.)	40-120 A	15-19 V	4.0-8.0 m/min (157-315 in./min)
1.0 mm (0.040 in.)	60-220 A	15-28 V	4.0-12.0 m/min (157-472 in./min)
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)
1.6 mm (1/16 in.)	230-350 A	25-30 V	3.0-5.0 m/min (118-197 in./min)