



Characteristics and scope of application

- Filler metal for NiCrFe-alloys
- Recommended for cladding and dissimilar welds of NiCrFe-alloys and steels

Standard designations

DIN EN ISO 18274	AWS A5.14	DIN Mat.-No.
S Ni 6076 (NiCr20)	ERNiCr-6	2.4639

Typical chemical composition of filler metal

	C	Cr	Ni	Si	Mn
Mass %	<0.1	20	Bal.	0.15	0.1

All weld metal properties (min. values at rt)

Heat treatment	Yield strength	Tensile strength	Elongation	Impact toughness	
	R _{p0.2}	R _m	A ₅	ISO-V	
as welded	320 MPa	550 MPa	25%	120 J	60 J / -196°C

Welding instructions

Polarity	Shielding gas acc. to DIN EN ISO 14175
DC / +	I1, I3, Z (ArHeHC-30/2/~0.1)
DC / -	I1, I3, R1 (max. 5% H ₂)
Low heat input and interpass temperature < 120°C. Stringer bead technique recommended.	
Base materials	
2.4816 – NiCr15Fe – Alloy 600 – UNS N06600	
2.4630 – NiCr20Ti – UNS N06075	

Packaging (tolerances acc. to DIN EN ISO 544)

Diameter (mm)		Kg
1.6 / 2.0 / 2.4 / 3.2	X 1000 mm	5 / 10
0.8 / 1.0 / 1.2	BS 300 spool	15
1.6 / 2.4 / 3.2	K 415 / K 435 spool	25

Approvals on request