Technical Datasheet
IGS-Chronin 80/20
Wire Electrode / Welding Wire / GTAW Rod

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 / -321°F

Welding instructions

Polarity	Shielding gas acc. to AWS A5.32
DC / +	SG-A, SG-AHe, SG-A-G (He 30% - H 2% - C ~0.1)
DC / -	SG-A, SG-AHe, SG-AH (max. 5% H_2)
Low heat input and interpass temperature < 248°F. Stringer bead technique recommended.	
Base materials	
2.4816 – NiCSG-AH5Fe – Alloy 600 H – UNS N06600	
2.4630 –NiCr20Ti – UNS N06075	

Packaging (tolerances acc. to AWS A5.02)

Diameter (in)		lbs/PU
1/16 - 1/8	x 36 in	11 / 22
0.8 / 1.0 / 1.2	BS 300 spool	33
1.6 / 2.4 / 3.2	K 415 / K 435 spool	55

Approvals on request

Deutsche Nickel