



Characteristics and scope of application

- Filler metal for Alloy 59 and similar wrought and cast grades
- Excellent corrosion resistance in acids and alkaline media
- Very good processability and low susceptibility to sensitization

Standard designations

DIN EN ISO 18274	AWS A5.14	DIN Mat.-No.
S Ni 6059 (NiCr23Mo16)	ERNiCrMo-13	2.4607

Typical chemical composition of filler metal

	C	Si	Cr	Mo	Ni	Fe
Mass %	<0.005	0.05	23	16	Bal.	< 0.5

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	450 MPa	760 MPa	30%	100 J	

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 required. Stringer bead technique recommended.
Reducing shielding gases are preferable for welding of corrosion resistant alloys.

Base materials
2.4605 – NiCr23Mo16Al - Alloy 59 – UNS N 06059
2.4610 – NiMo16Cr16Ti – Alloy C4 – UNS N06455

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