

GETIG 824

IDENTIFICATION

Getig 824, ERNiCrMo14

CLASSIFICATION

AWS/SFA-5.14 ER NiCrMo14,
(EN) ISO 18274 - SNI6686 (NiCr21Mo16W4)

DESCRIPTION

Solid nickel-base wire with widespread applications. The wire gives a strong tough corrosion and heat resistant deposit. The deposited welds are of X-Ray quality.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	W	Mo	S	P	Cu	Ti	Fe	Al	Ni+Co
0.01 Max	1 max	0.08 max	19 - 23	3.0 - 4.4	15 - 17	0.02 max	0.02 max	0.5 max	0.25 max	5 max	0.5 max	Bal.

TYPICAL APPLICATIONS

- It is used for welding of duplex, super duplex & super austenitic stainless steel. various grades of
- Used for depositing overlays having outstanding corrosion resistance properties. The high alloy levels (of Cr+Mo+W) result in increased resistance to pitting, crevice and general corrosion.
- The filler wire is used where corrosion resistance are required in media like HCL or sulfuric acid, for resistance to crevice corrosion in hot, concentrated acid chloride solutions such as sulfur dioxide, saturated NaCl solutions, oxidising chloride solutions.
- Use for cladding overlays, pumps, valves joining faces in off-shore and marine environments.

CORROSION RESISTANCE

Very good resistance to general and intergranular corrosion. Maximum resistance to pitting corrosion crevice corrosion and stress corrosion cracking in chloride bearing environments.

SCALING TEMPERATURE : The weld metal is resistant to oxidation in air upto 1150°C.

WELDING CURRENT : DC (-)

SHIELDING GAS : 99.99% Argon 6-12 l/mn.

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000 / 500	5	5 x 4 = 20
2	1000 / 500	5	5 x 4 = 20
2.40 / 2.50	1000 / 500	5	5 x 4 = 20
3.15 / 3.20	1000 / 500	5	5 x 4 = 20