

GETIG 842

A VERSATILE TIG WIRE FOR WELDING OF SIMILAR COMPOSITION ALLOYS.

IDENTIFICATION

Getig 842, ERNiCrFe12

CLASSIFICATION

AWS/SFA 5.14 ER NiCrFe12

DESCRIPTION

Getig 842 is intended for welding similar composition alloys. The deposit tolerates high dilution levels and is very resistant to hot cracking. It is not susceptible to sigma phase embrittlement or carbon migration and is therefore ideal for service at elevated temperatures. The weld metal passes X-ray quality

CHEMICAL ANALYSIS (RANGE) %

C	Cr	Mn	Si	P	S	Cu	Fe	Co	Al	Ti	Ni
0.15 - 0.25	24.0 - 26.0	0.5 max	0.35 max	0.02 max	0.01 max	0.1 max	8.0 - 11.0	1 max	1.8 - 2.4	0.10 - 0.20	Rem.

TYPICAL APPLICATIONS

Used for welding Nickel-Chromium-Iron-Aluminum alloy (ASTM B163, B166, B167, B168, B366, B516, B517, B546, UNS No. N06025) to itself and welding Ni-Cr-Fe to steel and other nickel base alloys.

SHIELDING GAS: Ar 99.99 %, 16-21 l/min; Ar +30% He, 20-25 l/min

CORROSION RESISTANCE

Extremely good resistance to general corrosion and very good resistance to stress corrosion cracking.

HIGH TEMPERATURE PROPERTIES

Resistance to oxidation in air upto 1150° C.

PACKING PARAMETERS

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