

GM 832

IDENTIFICATION

GM 832, ERNiCrMo2

CLASSIFICATION

AWS/SFA-5.14 : ERNiCrMo2

DESCRIPTION

The nominal composition (wt%) of filler metal of this classification is 47Ni, 22Cr, 18 Fe, 9Mo, and 1.5 Co.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Nb	Mo	S	P	Cu	Co	Fe	Ni	W	Others
0.05 - 0.15	1 max	1 Max	20.5 - 23	3.15 - 4.15	08-Oct	0.03 max	0.04 max	0.5 max	0.5 - 2.5	17 - 20	Bal.	0.2 - 1.0	0.5

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
650 min	30 min

TYPICAL APPLICATIONS

- Used for welding nickel-chromium-molybdenum alloy (ASTM B366, B435, and B572 having UNS number N06002) to itself, to steel, to other nickel-base alloys.
- For cladding steel with nickel-chromium-molybdenum weld metal.

WELDING CURRENT : DC (-)

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

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5 / 15.0
1	12.5 / 15.0
1.2	12.5 / 15.0
1.6	12.5 / 15.0