



PRODUCT DATA SHEET

WCD 6435

LOW ALLOY STEEL SOLID MIG WIRE

AUSTMIG NiCrMo



- ▶ Copper Coated, Low Alloy Gas Metal Arc (MIG) Welding Wire
- ▶ All Positional Welding of Medium and High Strength Steels
- ▶ Welded Strength 760 Mpa Tensile Class.

Classifications

AS/NZS 2717.1 ESMG-GM-W769AH-G

AWS A5.28 ER110S-G

Description & Applications

AUSTMIG NiCrMo is a copper coated, low alloy solid wire suitable for the all positional welding of high strength steels using Argon + CO₂ gas mixtures. AUSTMIG NiCrMo is ideal for the full strength welding of quenched and tempered structural steels, of the 760 Mpa tensile class, such as USS-T1, CcMo Pipe, Welten 80, X80, N-A-XTRA and Bisplate 80.

Operational Data

WIRE SIZE (mm)	WELDING CURRENT RANGE (amps)	ARC VOLTAGE RANGE (volts)*
0.9	70 - 230	15 - 26
1.2	120 - 350	18 - 32

Welding Current DC+

* Voltage is determined by arc current and wire arc length. Welding currents and voltage shown are operational guides only.

NOTE: Austmig NiCrMo is **NOT** to be used in weldments which are to be stress relieved. It is recommended that a 'Vanadium Free' welding wire be used such as our Fluxofil M42.

Typical All Weld Metal Chemical Analysis

C	Mn	Si	Ni	Cr	Mo	V	Fe
0.07	1.22	0.37	1.42	0.29	0.24	0.07	Bal

Typical All Weld Metal Mechanical Properties

Gas Type	Ar+18% CO ₂
Yield Stress	732 Mpa
Tensile Strength	799 Mpa
Elongation	18%
CVN Impact Values	78J@ -51°C

In as welded position

NOTE: The use of less oxidizing argon based gas mixtures (ie Ar/O₂, Ar/CO₂, Ar/CO₂/O₂), will result in higher alloy recovery in the weld metal, leading to higher tensile properties.

Packaging Data

PACK SIZE AND TYPE	PART NUMBER
15kg	MNICRMO09S
15kg	MNICRMO12S

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.*

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.

Issue AA

31/10/2006

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