

WISDOM Welding Consumables

Nickel based alloy



AWS ERNiFeCr-2

DATA SHEET

November 2015

Key features:

- ① used by GTAW process for Cr-Ni-Nb-Mo alloys.
- ② Used for welding alloys 718, 706 and X-750.
- ③ Used for welding high strength aircraft components and liquid rocket
Components involving cryogenic temperatures

Conformances

ERNiFeCr-2 ASME II

UNS N07718

AWS 5.14

CHEMICAL COMPOSITION(%)						
C	Si	Mn	S	P	Ni	Cr
≤0.08	≤0.35	≤0.35	≤0.015	≤0.015	50-55	17-21
Al	Ti	Fe	Cu	Mo	Nb+Ta	Co
0.2-0.8	0.65-1.15	Rest	≤0.3	2.8-3.3	4.75-5.5	≤1.0

MECHANICAL PROPERTIES		
Tensile Strength	125,00 PSI	860 MPA
Yield Strength	91,000 PSI	630 MPA
Elongation	27%	

Diameter & Packaging				
Form	Diameter		Standard Packaging	
			spool	tube
TIG	1/16" (1.6mm)	15kg/spool	5kg/tube	
	3/32" (2.4mm)	15kg/spool	5kg/tube	
	1/8" (3.2mm)	15kg/spool	5kg/tube	
MIG	.035" (0.9mm)	15kg/spool	5kg/tube	
	.045" (1.2mm)	15kg/spool	5kg/tube	
	1/16" (1.6mm)	15kg/spool	5kg/tube	