

ERNiCrMo-4








ERNiCrMo-4 is nickel based type material designed for welding of CrMoW-alloyed nickel alloys. Maybe used for cladding and welding of dissimilar materials of nickel base alloys, stainless steels, mild and low-alloyed steels. Depending on the corrosion requirements also suitable for welding of C-22 and C-4 alloys. Characterized by excellent resistance to stress corrosion cracking, pitting and crevice corrosion and extreme resistance to corrosion environments containing sulphuric acid and chlorides. Applicable for surfacing in high temperature applications (up to 1200°C).

Typical application area: pumps, valves, pipework and vessels in chemical process plant, equipment for flue gas desulphurisation and for offshore in oil & gas field.

1. Shielding gases (acc. EN ISO 14175)

GTAW	I1	Inert gas Ar (100%)
GMAW	I3	Inert gas Ar + 0÷95% He

2. Welding positions

						
PA	PB	PC	PD	PE	PF	PG

3. Chemical composition %

C	Mn	Si	S	P	Ni	Cr	Mo	W	Fe
≤0.02	≤1.00	≤0.08	≤0.03	≤0.04	rest	14.50-16.50	15.00-17.00	3.00-4.50	4.00-7.00
V	Cu	Co	Other						
≤0.35	≤0.50	≤2.50	≤0.50						

4. Mechanical properties, all weld metal

Heat treatment	Yield Strength, R _{p0.2} (MPa)	Tensile Strength, R _m (MPa)	Elongation, A (%)	Impact Energy ISO-V(J)	
				+20°C	-196°C
AW	≥400	≥690	≥25	≥90	-

5. Available size and packaging

Process	Diameter, mm	Box 5-10 kg	D100 1 kg	D200 5 kg	D300 15 kg	BS300 15 kg	K300 15 kg	Coil 25-40 kg	Drum 100-300 kg
GTAW	1.00 - 5.00	x	-	-	-	-	-	-	-
GMAW	0.60 - 2.00	-	-	-	-	x	-	-	-

* Customer packing on request.

Note: All information enclosed in this datasheet is based on our best knowledge and is given as indicative. Other special requirements are subject to prior discussion and approval of Vojay. Please contact us for any additional information or request.