ERNiFeCr-2

ERNiFeCr-2 is nickel based type material designed for welding of alloys 718, 706 and X-750 .

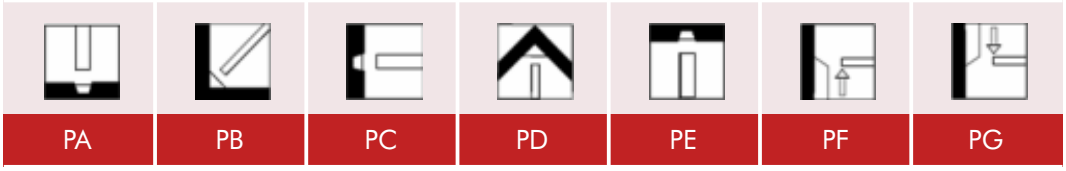
Characterized by excellent corrosion resistance to many media.

Typical application: components for liquid fueled rockets, rings, casings and various formed sheet metal parts for aircraft and land-based gas turbine engines, and cryogenic tankage, fasteners and instrumentation parts. Can be also used for cladding and overlay of parts in the oil and gas industry.

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	Al	Fe
≤0.08	≤0.35	≤0.35	≤0.015	≤0.015	50.00-55.00	17.00-21.00	2.80-3.30	0.20-0.80	rest

Ti	Cb+Ta	Cu	Other
0.65-1.15	4.75-5.50	≤0.30	≤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	≥800	≥1140	≥25	-	-

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.