# PRODUCT DATA SHEET

WCD 6435

SOLID MIG WIRES - LOW ALLOY STEEL

# Austmig NiCrMo


## SUMMARY

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

## CLASSIFICATION

- AS/NZS 16834-B G 78A 5U M21 G
- AWS A5.28 ER110S-G

## DESCRIPTION AND APPLICATION

Austmig NiCrMo is a copper coated, low alloy solid wire suitable for the all positional welding of high strength steels using Argon + $CO_2$ 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, Weldox 700, X80, N-A-XTRA and Bisplate 80.

## OPERATIONAL DATA

| WIRE SIZE (MM) | WELDING CURRENT RANGE (A) | ARC VOLTAGE RANGE *(V) |
|---|---|---|
| 0.9 | 70 - 230 | 15 - 26 |
| 1.2 | 120 - 350 | 18 - 32 |

Welding Current DC +
*Voltage is determined by arc current and electrode 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.

## TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

| C | Mn | Si | Ni | Cr | Mo | V | Fe |
|---|---|---|---|---|---|---|---|
| 0.09 | 1.59 | 0.54 | 1.45 | 0.31 | 0.23 | 0.09 | Bal |

## TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

| | |
|---|---|
| Gas Type | Ar+18% $CO_2$ |
| Yield Stress | 770 MPa |
| Tensile Strength | 880 MPa |
| Elongation | 18% |
| CVN Impact Values | 68J @ -50°C |

In as welded condition.

NOTE: The use of less oxidizing argon based gas mixtures (ie $Ar/O_2$, $Ar/CO_2$, $Ar/CO_2/O_2$), will result in higher alloy recovery in the weld metal, leading to higher tensile properties.

## PACKAGING DATA

| WIRE SIZE (MM) | PACK SIZE AND TYPE | PART NO. |
|---|---|---|
| 0.9 | 15kg Spool | MNICRMO09S |
| 1.2 | 15kg Spool | MNICRMO12S |



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