



# PRODUCT DATA SHEET

## SOLID MIG WIRES - LOW ALLOY STEEL

WCD 6435

### Austmig NiCrMo



#### SUMMARY

- > 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

#### 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<sub>2</sub> 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, Weldom 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 <sub>2</sub>
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<sub>2</sub>, Ar/CO<sub>2</sub>, Ar/CO<sub>2</sub>/O<sub>2</sub>), 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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