STELLOY C-G

CLASSIFICATION

EN 14700: TNi2 AWS A 5.21 / ASME II C SFA 5.21: ERCNiCrMo-5A DIN 8555¹: MSG 23-GF-200/350-CKNTZ

¹ Former classification replaced by EN 14700

DESCRIPTION

Nickel-based super-alloy flux-cored wire of the NiCrMoW type

• Particularly resistant to corrosion under oxidising and reducing atmospheres

• Weld metal is designed to withstand impact, compression, abrasion, oxidation, corrosion and heat up to 1100°C

• Excellent thermal shock resistance

• Can be machined without previous heat treatment

APPLICATIONS

STELLOY C-G is suitable for welding of joints in steel clad with a nickel-chromium-molybdenum alloy and for the joining of nickel-chromium-molybdenum alloys to steel or to other nickel base alloys.

Base materials : UNS N 10002 (ASTM B 334, B 336, B 366)

STELLOY C-G is also destined in general to surface all parts undergoing mechanical stress combined with corrosion, thermal shocks and/or high temperatures

Examples

Hot shear blades, lime kiln burner parts, dies, swages, press tools as well as pump parts, hot-piercing punches, rolling and wire-drawing guides, valves and reservoirs...

TYPICAL ALL-WELD METAL ANALYSIS											
С	Mn	Si	Cr	Мо	Fe	W	Ni				
0.05	0.60	0.50	16.00	16.00	5.00	4.50	Bal.				
TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES											
TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES											

Hardness:

As welded: 200 HB Work hardened: 350 HB

SHIELDING GAS												
I1 according to EN ISO 14175 (pure Argon)												
CONDITIONS OF USE												
Current type	Gas			Gas flow rate		Recovery						
DC(+) or pulsed	EN ISO 14175: I1 (Argon)			10 - 20 l/min		98%						
OPERATING CONDITIONS												
Diameter [mm]	Amperage [A]			Voltage [V]	Stick-out [mm]							
	Range	Optimum	Range	Optimum	Range	Optimum						
1.2	100 - 250	200	16 - 29	28	15 - 30	20						
1.6	140 - 350	250	16 - 30	28	15 - 30	20						
Recovery: 98 %												
WELDING POSITIONS												
EN ISU 6947: PA, PB, PU												
STANDARD DIAMETERS (mm)												
1.2, 1.6 mm												
Other diameters: please consult us												
PACKAGING												
Diameter	2.4 mm			2.4 mm								
Standard packaging	g Spool EN ISO 544: BS 300			Metal basket rim EN ISO 544: B450		Drum						
Weight	15 kg			25 kg		Up to 300 kg						