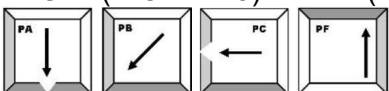
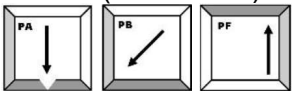


# DT-2.4806

## Nickel Alloy MIG/MAG-Wire TIG – Rods

|   |   |
|---|---|
| <b>Specifications</b>                                 | EN ISO 18274: SG - NiCr20Mn3Nb (S Ni 6082)<br>AWS A5.14-Spec.: ER NiCr-3  |
| <b>Application</b>                                    | NiCrFe-wire/rod for joining NiCr-alloys, sub-zero tough nickel alloys down to – 196°C, heat resisting austenitic steels and dissimilar steels up to + 550°C. Scale resistant in air and oxidising combustion gases up to + 1000°C.  |
| <b>Chemical Composition<br/>Element by weight (%)</b> | Ni: Bal. C: 0,02 Cr: 20,0 Mn: 3,0 Fe: 2,0 Nb: 2,5   |
| <b>Mechanical Properties<br/>(typical)</b>            | 0,2% Elongation (Rp0,2) 400 N/mm <sup>2</sup><br>Tensile Strength (Rm) 650 N/mm <sup>2</sup><br>Elongation (A)(Lo=5do) 40%<br>Impact energy (Av) 150 J  |
| <b>Approvals</b>                                      | TÜV, CE-Zeichen   |
| <b>Shielding gas/Polarity</b>                         | <p>WIG: (ISO 14175) I1 (=–)</p>  <p>MSG: (ISO 14175) I1 (=+)</p>   |
| <b>Typical Base Material</b>                          | 2.4816                      2.4951                      2.4806<br>1.4876                      1.4886                      1.5662<br>1.4961    1.4981    1.4988                      1.5680<br>ISO 20172: Gruppe 8.1 verschweißt mit Gruppe 1.2<br>ISO 20172: NiCr15Fe<br>ISO 20172: NiCr15Fe verschweißt mit Gruppe 1.2 |
| <b>Packaging</b>                                      | MIG/MAG: spools D 100 / D 200 / K 200 / K 300<br>TIG: 10-kg-boxes   |