

## MIG-MAG Wires Nickel and Copper alloys

Nifil 600 is a solid wire for welding Inconel 600 and Incoloy 800. Nifil 600 is also suitable for welding dissimilar or difficult to weld steels, particularly Ni alloys and stainless steels. Excellent mechanical properties and corrosion resistance at high temperatures up to 1100°C.

### Classification

|        |                  |
|--------|------------------|
| AWS    | A5.14: ER NiCr-3 |
| EN ISO | 18274: S Ni 6082 |

### Approvals

### Grades

### Analysis of all-weld metal (Typical values in %)

| C    | Mn | Si   | P       | S       | Cr | Ni | Mo | Nb | Fe | W | Cu |
|------|----|------|---------|---------|----|----|----|----|----|---|----|
| 0.01 | 3  | 0.30 | ≤ 0.030 | ≤ 0.015 | 20 | 67 | -  | 2  | 2  | - | -  |

### All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>A5 (%) | Impact Energy<br>ISO - V (J)<br>-196°C | Hardness |
|----------------|-------------------------------------|---------------------------------------|----------------------|--|----------|
| As Welded      | ≥ 380                               | ≥ 550                                 | ≥ 25                 | ≥ 55                                   | -        |

Gas test: Acc. To EN 439: M13(Cargal1)

**Shielding Gas:** Acc. To EN 439: M13(Cargal1) or I3(Arcal37)

### Materials

2.4816; 1.4876; 1.4958

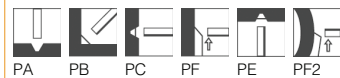
UNS N06600; UNS N08800; UNS N08810

### Storage

Keep dry and avoid condensation.

### Current condition and welding position

DC+



**Packaging data:** K300 Kg. 16

| Diameters | 0,8 | 1,0 | 1,2 | 1,6 |  |  |
|-----------|-----|-----|-----|-----|--|--|
|-----------|-----|-----|-----|-----|--|--|