

Exaton Ni55

Exaton Ni55 is a nickel-chrome-molybdenum alloy of type alloy 686 and is the highest alloyed of all Ni-Cr-Mo alloys. Exaton Ni55 is used for joining nickel alloy such as UNS N06022 (2.4602), UNS N06059 (2.4605), UNS N10276 (2.4819) and super duplex.

The material is thermally unstable at temperatures above 1200°C (2192°F) resulting in great risk for intermetallic phases after welding.

Exaton Ni55 provides the best corrosion resistance in most applications and is particularly useful for weld overlay surfacing of boiler tubes in waste-to-energy boilers. Also, the material can be used in the petrochemical, chemical, oil and gas and marine industries. It is used for MIG/MAG welding.

Классификация сварочной проволоки	SFA/AWS A5.14 : ERNiCrMo-14 EN ISO 18274 : S Ni6686 (NiCr21Mo16W4)
Одобрения	CE EN 13479

Одобрения на материалы выдаются с привязкой к заводу изготовителю. Подробную информацию можно получить в представительствах ESAB.

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
После сварки	20 °C	110 J
После сварки	-196 °C	75 J

Хим. состав проволоки

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.01	0.4	0.06	0.003	0.02	57	20	16	0.3	0.05

Хим. состав проволоки

Ti	Fe	W
0.1	0.6	3.5

Данные наплавки

Диаметр проволоки	Current	Voltage	Wire Feed Speed
1.2 mm	150-260 A	24-29 V	3.0-10.0 m/min