

## NC 80/20 Filler Metal

**NC 80/20 Filler Metal Wire** is a nickel-chromium material used for the gas-tungsten-arc and gas-metal-arc welding of NIMONIC 75, and INCOLOY alloy DS, and the Brightway alloys to themselves and to each other. The shielding gas should be Argon, Helium, or a mixture of the two. It may also be used in many dissimilar metal applications, especially where carbon steels are joined to stainless steels and to Nickel-based alloys. Weld overlaying of carbon and low alloy steels is another popular application.

### Specifications

BS 2901 (NA34)  
 \*DIN 1736 SG-NiCr20 (2.4639)  
 \*(EN) ISO 18274 – SNi6076 (NiCr20)  
 \*Supply to these specifications available upon request  
 For manufacture to ASME III (NCA3800, NB2400), Rolls Royce, AMS and other specifications please refer your inquiry to the Technical Department prior to order placement.

### Approvals

Approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

### Limiting Chemical Composition

Ni .....	Balance	Fe .....	0.5 max.
Cr .....	18 to 21	Si .....	0.5 max.
Mn .....	1.2 max.	Cu .....	0.2 max.
Co.....	1.0 max.	C.....	0.26 max.

### Minimum Mechanical Properties

Tensile Strength, psi	80,000
MPa	552
Elongation, (4d) %	25

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

### Available Product Forms

<b>mm</b>	0.8	0.9	1.0	1.14	1.2	1.6	2.4	3.2
<b>in</b>	0.030	0.035	0.040	0.045	0.047	0.062	0.093	0.125

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)

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