

Alloy X

CATEGORY GMAW-GTAW Solid wires

PROPERTIES Alloy X is a nickel- chromium-iron-molybdenum alloy that possesses an exceptional combination of oxidation resistance, fabricability and high-temperature strength. It has also been found to be exceptionally resistant to stress-corrosion cracking in petrochemical applications. X alloy exhibits good ductility after prolonged exposure at temperatures of 1200, 1400, 1600F (650, 760 and 870C) for 16,000 hours. Suitable for joining and cladding Nickel alloys, stainless steel, carbon steel and low alloyed steels. UNS: N06002

CLASSIFICATION

AWS	A 5.14: ER NiCrMo-2
EN ISO	18274:
DIN: W.Nr.	2.4665
DIN	1736:

SUITABLE FOR Alloy HX, X, Nickel alloys, stainless steel, carbon steel and low alloyed steels. UNS: N06002

WELDING POSITIONS:



Ni	Co	Fe	Cr	Mo	W	Mn	Si	C	B
Bal.	1.5	18	22	9	0.6	1	1	0.10	0.008

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Packing kg / can
	Length (mm)	Current (A)	
1.2	915		2.27
1.6	915		2.27
2.4	915		2.27