Technical data sheet 011121MBA	Cored welding wire # GAMMA 254	Welding Alloys

CLASSIFICATION

AWS A 5.34 / A5.34M: - [1]
EN ISO 12153: T Z Ni 6012 (NiCr22Mo9) B M21 3

[1]There is no classification available for this weld metal composition.
The deposit meets the composition of the ENiCrMo-12 nickel-base SMAW electrodes.

DESCRIPTION

- Special flux cored nickel base wire for gas shielded arc welding
- Latest generation basic slag quality guarantees optimum metallurgical quality and attractive welder appeal
- Together with enhanced productivity, GAMMA 254 offers many other advantages compared to solid wires: improved weldability, almost no spatter, better arc stability, enhanced wetting properties, better bead aspect and shape, and use of classical M21 gas mixtures
- Maximum performances in the horizontal and flat positions

APPLICATIONS

GAMMA 254 is suitable for joining chromium - nickel - molybdenum super austenitic steels to themselves, to duplex ferritic-austenitic stainless steels, to nickel-chromium-molybdenum alloys, and to steel.

Examples:

Alloy	UNS	EN Symbol	Material number
6% Mo super austenitics	N08028	X1 NiCrMoCu 31-27-4	1.4563
	N08031	X1 NiCrMoCu 32-28-7	1.4562
	N08926	X1 NiCrMoCuN 25-20-7	1.4529
	S31254	X1 CrNiMoCuN 20-18-7	1.4547

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Mo	Nb	Fe	Ni
0.03	0.04	0.25	21	9.5	1.5	2.0	Bal.

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
630	400	27	- 196°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
670	450	35	-196°C: 75

SHIELDING GAS

EN ISO 14175: M21 (Ar + 15 - 25% CO_2)

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC+	130 - 250	24 - 32	12 - 25	10 - 20 l/min.

WELDING POSITIONS

Flat, Horizontal

PACKAGING

Diameter	1.2 mm
	EN ISO 544 – ASME II C SFA-5.2 M
Spool type	BS300
Weight	15 kg

Other packaging and other diameters: please consult us