

GMAW Wire for Nickel and Nickel-Based Alloy

KMS-62

Classification

AWS A5.14/A5.14M	ERNiCrFe-5
JIS Z3334	SNi6062
EN ISO 18274	S Ni 6062
GB T15620	S Ni 6062

Shielding Gas:75% Ar+25%He

Applications and Features

- (1) KMS-62 is 74%Ni-16%Cr-8%Fe-2%Nb alloy.
- (2) The addition of Nb is to avoid the stress induced cracking of heavy plate .
- (3) Suitable for welding Inconel 600, Incoloy 80, ASTM B163, B166,B167 and B168 Ni-Cr-Fe alloy.
- (4) Ideal for welding offshore, LNG, pressure vessel and chemical equipment.

Welding Position



Welding Instruction

- (1) Clean surface of base metal before welding.
- (2) Heat input should be controlled as low as possible.
- (3) For other instructions, please refer to Appendix B.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Fe	Nb	Ni
0.03	0.22	0.65	0.006	0.001	14.83	7.86	1.99	74.15

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
651	401	45	-	-

Size and Suggested Operating Range (DC+)

Diameter (mm)	0.8	0.9	1.2	1.6
Current (A)	140~180	160~200	190~230	200~250
Voltage (V)	24~27	25~28	26~30	29~33