

## GMAW Wire for Nickel and Nickel-Based Alloy

# KMS-72

### Classification

AWS A5.14/A5.14M	ERNiCr-4
JIS Z3334	SNi6072
EN ISO 18274	S Ni 6072
GB T15620	S Ni 6072

Shielding Gas:75% Ar+25%He

### Applications and Features

- ( 1 ) KMS-72 is 55%Ni-44%Cr alloy.
- ( 2 ) The excellent corrosion resistance at high temperature due to high Cr content in atmospheres containing sulfur and vanadium.
- ( 3 ) Suitable for welding Inconel 671 and 690 alloy.
- ( 4 ) Ideal for cladding the water cooled wall of boiler with sulfur fuel .

### 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	Ti	Fe	Ni
0.02	0.02	0.09	0.003	0.001	42.42	0.54	0.08	56.50

### Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%	°C	J
735	558	40	-	-

### 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