

GMAW Wire for Nickel and Nickel-Based Alloy

KMS-X

Classification

AWS A5.14/A5.14M	ERNiCrMo-2
JIS Z3334	SNi6002
EN ISO 18274	S Ni 6002
GB T15620	S Ni 6002

Shielding Gas:75% Ar+25%He

Applications and Features

- (1) KMS-X is 47%Ni-22%Cr-18%Fe-9%Mo-1.5%Co alloy.
- (2) Suitable for welding Hastelloy X, Incoloy 800H/800H and ASTM B366, B435 and B572 Ni-Cr-Mo alloy.

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	Mo	Fe	Co	W	Ni
0.07	0.10	0.03	0.009	0.006	21.70	8.70	18.50	1.50	0.70	48.40

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
753	466	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