

Technical data sheet

011121MBA

Cored welding wire

GAMMA V CRYO**CLASSIFICATION**

AWS A 5.34: *ENiCrMo6T1-4
 AWS A 5.34M: *TNi 6620-14
 EN ISO 12153: T Z Ni 6620 (NiCr14Mo7Fe) P M21 1

*This classification has not yet been incorporated into AWS A 5.34 / AWS A 5.34M.
 The weld deposit conforms to that of covered electrodes classified under NiCrMo-6 /Ni 6620.

DESCRIPTION

- Flux cored nickel base wire for gas shielded arc welding
- Meets the NiCrMo-6 requirements
- Linear expansion coefficient equivalent to that of 9% Ni steel
- Designed for all-position operability

APPLICATIONS

- GAMMA V CRYO is especially designed for welding 9% nickel steel.
- It is also used for joining low alloyed steel for cryogenic applications.

Examples:

Alloy	UNS	EN Designation	Material Number
9% Ni steel	K81340	X8Ni9	1.5662
5% Ni steel	K41583	X12Ni5	1.5680
3.5% Ni steel		10Ni14 or 12Ni14	1.5637

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Mo	Nb	W	Fe	Ni
0.01	2.5	0.4	16.0	6.0	2.0	1.5	2	Bal.

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
690	430	25	-196°C: 60

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
720	470	40	-196°C: 100

SHIELDING GAS

EN ISO 14175: M21 (Ar + 15% < CO₂ ≤ 25%)

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow [l/min]
1.2	DC+ or AC	130 - 220	24 - 32	12 - 25	10 - 20

WELDING POSITIONS

All positions

PACKAGING

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

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.