

**Technical
data sheet**

140222JMBA

Cored welding Wire
STELLOY C-S**CLASSIFICATION**EN 14700: T Ni2
AWS A 5.21 / ASME II C SFA 5.21: ERCNiCrMo-5A**DESCRIPTION**

- Nickel-based super-alloy metal cored wire of the NiCrMoW type
- Particularly resistant to corrosion under oxidising and reducing atmospheres
- Weld metal is designed to withstand impact, compression, abrasion, oxidation, corrosion and heat up to 1100°C
- Excellent thermal shock resistance
- Can be machined without previous heat treatment

APPLICATIONS

STELLOY C-S is suitable for welding of joints in steel clad with a nickel-chromium-molybdenum alloy and for the joining of nickel-chromium-molybdenum alloys to steel or to other nickel base alloys.

Base materials : UNS N 10002 (ASTM B 334, B 336, B 366)

STELLOY C-S is also destined in general to surface all parts undergoing mechanical stress combined with corrosion, thermal shocks and/or high temperatures

Examples

Hot shear blades, lime kiln burner parts, dies, swages, press tools as well as pump parts, hot-piercing punches, rolling and wire-drawing guides, valves and reservoirs...

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Fe	W	Ni
0.05	0.60	0.50	16.0	16.0	5.00	4.50	Bal.

TYPICAL WELD DEPOSIT PROPERTIESHardness – as welded: 200 HB
Hardness – work-hardened: 350 HB**FLUX DESCRIPTION**

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	200 - 450	350	26 - 30	30	25 - 50	30
2.8	250 - 500	400	28 - 32	30	25 - 50	30

Recovery : 95%

Current type/polarity: DC+

WELDING POSITIONS

Flat

PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	EN ISO 544: BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 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.