



PRODUCT DATA SHEET

SOLID MIG WIRES - LOW ALLOY STEEL

WCD 6435

Austmig NiCrMo



SUMMARY

- > Copper Coated, Low Alloy Gas Metal Arc (MIG) Welding Wire
- > All Positional Welding of Medium and High Strength Steels
- > Welded Strength 760 MPa Tensile Class

CLASSIFICATION

- > AS/NZS 16834-B G 78A 4U M21 G
- > AWS A5.28 ER110S-G

DESCRIPTION AND APPLICATION

Austmig NiCrMo is a copper coated, low alloy solid wire suitable for the all positional welding of high strength steels using Argon + CO₂ gas mixtures.

Austmig NiCrMo is ideal for the full strength welding of quenched and tempered structural steels, of the 760 MPa tensile class, such as USS-T1, CcMo Pipe, Welten 80, Weldom 700, X80, N-A-XTRA and Bisplate 80.

OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
0.9	70 - 230	15 - 26
1.2	120 - 350	18 - 32

Welding Current DC +

*Voltage is determined by arc current and electrode arc length.

Welding currents and voltage shown are operational guides only.

NOTE: Austmig NiCrMo is NOT to be used in weldments which are to be stress relieved.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Ni	Cr	Mo	V
0.08	1.60	0.60	1.50	0.30	0.30	0.10

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	Ar+18% CO ₂
Yield Stress	750 MPa
Tensile Strength	800 MPa
Elongation	19%
CVN Impact Values	70J @ -40°C

In as welded condition.

NOTE: The use of less oxidizing argon based gas mixtures (ie Ar/O₂, Ar/CO₂, Ar/CO₂/O₂), will result in higher alloy recovery in the weld metal, leading to higher tensile properties.

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
0.9	15kg Spool	MNICRMO09S
1.2	15kg Spool	MNICRMO12S

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Issue CA - November 2021



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