

GEN⁴ NICKEL WELDING WIRE

Nickel and Nickel Alloys are used in a variety of applications that require extreme thermal and/or corrosion resistance beyond what is achievable with stainless steel alloys. CWI Generation4™ Nickel Welding consumables are available in a wide range of Nickel Wire Alloys for use with all conventional welding processes. Below is a list of the standard nickel welding consumables we stock, and their typical chemical composition:

Typical Chemical Composition of Gen ⁴ of Nickel Wires															
Product	Specifications AWS A5.14	C	Mn	Si	Fe	Cr	Mo	Ni	Nb+ Ta	W	S	P	Al	Ti	Cu
GEN 55		0.05	0.25	0.15	43.60			55.90							
GEN 72	ERNiCr-4	0.03				43.60		Bal						0.50	
GEN 99	ERNiCr (AWS AS.15)	0.05	0.22	0.05				99.60							
GEN 208 (FM 61)	ERNi-1	0.06	0.30	0.40	0.10			95.50			0.003	0.008	0.50	3.0	<15%
GEN 276	ERNiCrMo-4	0.01	0.55	0.04	5.50	15.55	16.10	Bal		3.65	0.002	0.009			
GEN 413 (FM 67)	ERCuNi (AWS A5.7)		0.75	0.10	0.55			1.0				0.006		0.35	Bal
GEN 418 (FM 60)	ERNiCu-7	0.05	3.45	0.77	0.40			65.20			0.002	0.009	0.10	2.25	Bal
GEN 606 (FM 82)	ERNiCr-3	0.03	2.85	0.22	1.10	20.40		72.90	2.50		0.001	0.003			
GEN 617 (FM 617)	ERNiCrCoMo-1	0.06	0.20	0.11	0.75	21.80	9.05	Bal			0.001	0.005	1.25	0.25	1245Co
GEN 622/622LHIW (FM 622)*	ERNiCrMo-10	0.008	0.20	0.04	3.10	21.50	13.50	Bal		3.50	0.002	0.005			
GEN 625/625LHIW (FM 625)*	ERNiCrMo-3	0.009	0.05	0.12	0.62	21.90	8.65	64.50	3.70		0.002	0.006	0.17	0.19	
GEN 686	ERNiCrMo-14	0.01	1.00	0.08	5.00	0.50	16.50	Bal		3.80	0.02	0.02	0.50	0.25	0.50
GEN 718 (FM 718)	ERNiFeCr-2	0.04	0.25	0.20	17.55	19.0	3.10	53.30	5.05		0.004	0.001	0.40	0.90	
GEN 825 (FM 65)	ERNiFeCr-1	0.01	0.45	0.25	29.0	21.50	3.10	42.60			0.001	0.015	0.10	1.0	2.0

*Low Heat Input Wire

