

INCOLOY® Filler Metal 65



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INCOLOY Filler Metal 65 is used for gas-tungsten-arc welding of INCOLOY alloy 825 and other nickel-iron-chromium-molybdenum-copper alloys of similar composition. The weld metal is highly corrosion resistant, particularly in reducing chemicals such as sulphuric and phosphoric acids. INCOLOY Filler Metal 65 can also be used for depositing overlays on carbon and low alloys steels.

Specifications

AWS A5.14 ERNiFeCr-1 (UNS N08065)

ASME II, Part C, SFA-5.14, ERNiFeCr-1 (UNS N08065)

ASME IX, F-No.45

*BS 2901 NA41

*(EN) ISO 18274 – SNi8065 (NiFe30Cr21Mo3)

*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), Rolls Royce, AMS and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition

Ni+Co 38.0-46.0
C 0.05 max.
Mn 1.0 max.
Fe 22.0 min.
S 0.03 max.
Si 0.50 max.
Cu 1.5-3.0

Cr 19.5-23.5
Al 0.20 max.
Ti 0.60-1.20
Mo 2.50-3.50
P 0.03 max.
Others 0.50 max.

Minimum Mechanical Properties

Tensile Strength, psi 80,000
MPa 552
Elongation, (4d) % 25

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

Available Product Forms

mm in	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125
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Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)