

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 Gen⁴ 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

