

INCO-WELD® HX Filler Metal

INCO-WELD HX Filler Metal is used for gas-tungsten-arc and gas-metal-arc welding of INCONEL alloy HX and similar nickel-chromium-molybdenum alloys. It is also used for surfacing of steel. The weld metal has outstanding strength and oxidation resistance at temperatures up to 2200°F (1200°C).

Dissimilar-welding applications for INCO-WELD HX Filler Metal include welding INCONEL alloy HX to other nickel alloys, to stainless steels, and to carbon and low-alloy steels.

Specifications

AWS A5.14 ERNiCrMo-2 (UNS N06002)
ASME II, Part C, SFA-5.14, ERNiCrMo-2 (UNS N06002)
ASME IX, F-No.43
*BS 2901 NA40
*(EN) ISO 18274 – SNi6002 (NiCr21Fe18Mo9)
*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	Remainder	Cu.....	0.50 max.
C	0.05-0.15	Co	0.50-2.50
Mn	1.0 max.	Cr	20.5-23.0
Fe.....	17.0-20.0	Mo	8.0-10.0
P	0.04 max.	W	0.20-1.0
S	0.03 max.	Others	0.50 max.
Si.....	1.0 max.		

Minimum Mechanical Properties

Tensile Strength, psi	100,000
MPa	660
Elongation, (4d) %	30

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

Available Product Forms

mm	0.8	0.9	1.0	1.14	1.2	1.6	2.4	3.2
in	0.030	0.035	0.040	0.045	0.047	0.062	0.093	0.125

Straight Lengths - 915 mm (36 in.) or 1000 mm (39in.)

