



Techalloy 606 FCA

Description

Techalloy 606FCA is a gas shielded, all position flux cored wire that provides a final weld chemistry equivalent to the composition requirements of AWS A5.14 ERNiCr-3 solid wire. Used for dissimilar welding of Ni-Cr Alloys to Steel, surfacing of Carbon and Low Alloy Steels, joining of Ni-Cr alloys.

Specifications & Approvals:

AWS A5.34 ENiCr3T1-4 UNS W86082 CWB

Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	W	S	P	Al	Ti	Cu
.03	3.0	.30	0.5	20.0		BAL	2.5		.001	.010		.15	

Typical Mechanical Properties

Tensile Strength	80 KSI MIN	550 MPa MIN
Yield Strength		
Elongation	25% MIN	

Welding Parameters

Process	Electrical	Diameter	Voltage	Amperage	Extension	Gas	Welding Speed
FCAW	DCEP	.045" (1.14mm) .062" (1.60mm)	25-26 26-27	150-200 200-250	1/2" 1/2"	100% CO ² or 75% Argon + 25% CO ²	290-400 IPM

Standard Packages:

MIG Wire– 33# wire basket		
---------------------------	--	--