



Characteristics and scope of application

- Filler metal for Alloy 59 and similar wrought and cast grades
- Excellent corrosion resistance in acids and alkaline media
- Very good processability and low susceptibility to sensitization

Standard designations

DIN EN ISO 18274	AWS A5.14	DIN Mat.-No.
S Ni 6059 (NiCr23Mo16)	ERNiCrMo-13	2.4607

Typical chemical composition of filler metal

	C	Si	Cr	Mo	Ni	Fe
Mass %	<0.005	0.05	23	16	Bal.	< 0.5

All weld metal properties (min. values at rt)

Heat treatment	Yield strength	Tensile strength	Elongation	Impact toughness	
	Rp0.2	R _m	A ₅	ISO-V	
as welded	65 ksi	110 ksi	30%	100 J	

Welding instructions

Polarity	Shielding gas acc. to AWS A5.32
DC / +	SG-A, SG-AHe, SG-A-G (He 30% - H 2% - C ~0.1)
DC / -	SG-A, SG-AHe, SG-AH (max. 5% H ₂ DC / -)

Low heat input required. Stringer bead technique recommended.
Reducing shielding gases are preferable for welding of corrosion resistant alloys.

Base materials

2.4605 – NiCr23Mo16Al - Alloy 59 – UNS N 06059

2.4610 – NiMo16Cr16Ti – Alloy C4 – UNS N06455

Packaging (tolerances acc. to AWS A5.02)

Diameter (in)		lbs/PU
1/16 - 1/8	X 36 in	11 / 22
0.035 – 0.045	BS 300 spool	33
0.06 – 1/8	K 415 / K 435 spool	55

Approvals on request