

Technical annexure II

ERNiCrMo-3 (UNS N06625) as per ASME Sec IIC, SFA 5.14 and requirement given below.

Sl. No.	Parameters	GMAW Wire (ERNiCrMo-3)
1	Mechanical Properties	Mechanical Properties: - HT condition: 630 Deg.C; Soaking : 120 minutes - Impact test for deposited Weld Metal @-29 Deg.C; 20 J minimum - Hardness Test: 250 HV10 Max. %Fe (Mass fraction) in deposited weld metal: 5.0 Maximum. - Weld metal Tensile Strength : 760 MPa, minimum .
2	Chemical analysis of wire	ERNiCrMo-3 (UNS N06625) as per ASME Sec IIC, SFA 5.14
3	Diameter	0.8 mm /0.9 mm /1.0 mm /1.2 mm
4	Shielding Gas	Argon (95%) +CO2 (5%)
5	Spool weight	5 Kg
6	identification	Adhesive label on spool basket
7	Radiographic Soundness & Usability	The wire when used as an electrode in GMAW with Argon (95%) +CO2 (5%) shall deposit a weld metal that flows freely, uniformly without sputtering or other defects and shall exhibit excellent wetting characteristics. The resultant weld metal shall be smooth, uniform with no visible evidence of cracks, porosity or other defects and shall meet the radiographic soundness requirements as per ASME SEC IIC SFA 5.14 ERNiCrMo-3.
8	Size	The wire shall be supplied in diameter 0.8 mm /0.9 mm /1.0 mm /1.2 mm as specified in the purchase order. The tolerance on diameter shall be as per SFA-5.02.
9	Form and Weight	The wire shall be precision layer wound in S300 plastic spools and the net weight of the wire shall be 5 Kg. The spools shall meet the clause 4.3.4 of SFA-5.02.
10	Finish & Uniformity	The wire shall meet the requirements of clause 4.2 of SFA-5.02
11	Packaging	The wire should be completely devoid of moisture or any other foreign material with adequate sealing in suitable cartons to ensure no deterioration in the electrode quality during transportation by sea or long duration storage
12	Testing and certification	Manufacturer certificate shall have following test results. - Chemical analysis of wire. - Weld metal mechanical properties [Impact test for deposited Weld Metal at -29 Deg.C, Hardness, %Fe (Mass fraction) in deposited weld metal, Weld metal Tensile Strength ,RT]. Note: All mechanical properties of weld metal must be reported after heat treatment (HT condition: 630 Deg.C; Soaking : 120 minutes)