



Nickel Alloy Consumables for GTAW, GMAW and SAW Welding

Product Name	AWS A5.9 / EN 12072	Applications and Characteristics	Typical Chemical Analysis %		Typical Mechanical Properties	
					Tensile Strength MPa	EL %
Revofil 625	ER NiCrMo-3 ISO SNI6625	For welding of Alloy 625, Alloy 825, Alloy 25-6MO, and other molybdenum-containing stainless steels. This filler metal is used for surfacing of steel, welding nickel steels, and welding various corrosion-resistant alloys such as alloy 20.	C Mn Si Cr Ni Mo Fe	0.01 0.034 0.08 22.4 Rem 8.73 1.0 max	780	35
Revofil 622	ER NiCrMo-10 ISO SNI6022	For welding of Alloys 22, 622 and 625, Alloy 25-6MO, and Alloy 825. Dissimilar joints involving Ni-Base alloy, and carbon steel, low-alloy and stainless steels.	C Mn Si Cr Ni Mo	0.01 0.35 0.06 21.5 Rem 13.5	790	40
Revofil C-276	ER NiCrMo-4 ISO Ni6276	For welding of Alloy C-276 and other Ni-Cr-Mo alloys. Dissimilar welding applications include welding alloy C-276 to other Ni-Base alloys, to stainless steels, and to low-alloy steels.	C Mn Si Cr Ni Mo	0.01 0.6 0.03 15.2 Rem 16.2	690	30
Revofil 67	ER CuNi ISO S Cu 7158	For welding of Alloy 450 and other Cu-Ni alloys. It is used for surfacing of steel and the weld metal has excellent resistance to corrosion in sea water. Dissimilar joints involving Cu-Base alloys and Cu-Ni alloys.	C Mn Si Ni Cu	0.015 0.6 0.01 30.5 Rem	340	30
Revofil 60	ER NiCu-7 ISO SNI4060	For welding of Alloy 400. It is used for surfacing of steel and the weld metal has excellent resistance to corrosion in sea water. Revofil 60 is use as an under layer.	C Mn Si Ni Cu	0.08 3.0 1.15 63.8 Rem	485	30
Revofil 61	ER Ni-1 ISO Ni 2061	For welding of Alloy 200 and 201. Dissimilar joints involving Alloy 200 to stainless, carbon steel, Ni-Base Alloy and Cu-Ni. Also for joining Cu-Ni to carbon steel, Ni-Base alloys.	C Mn Si Ni Fe	0.08 0.6 0.5 95.2 1.0 max	410	20
Revofil 55	-	For welding of gray & ductile cast iron. It perform like 55%Ni type stick electrode. Dissimilar joints involving ductile cast iron and steel. Shielding Gas Argon or 75%Ar + 25%Co2.	C Mn Si Cr Ni Fe	0.01 0.3 0.11 0.03 54.7 44.6	410	35
Revofil 59	ER NiCrMo-13 ISO SNI6059	For welding of Alloy 625, Alloy 825, Alloy 25-6MO, and other molybdenum-containing stainless steels. This filler metal is used for surfacing of steel, welding nickel steels, and welding various corrosion-resistant alloys such as alloy 20.	C Mn Si Cr Ni Fe Mo	0.01 0.5 0.1 23.0 Rem 1.5 16.0	760	25
Revofil 82	ERNiCr-3 ISO Ni6082	For welding of Alloy 600, 601 and 690, alloy 800 and 800HT. This filler is used for surfacing of steel and the deposited weldmetal has high strength and good corrosion resistance, including oxidation resistance and high creep rupture strength at elevated temperatures. It is also used in dissimilar welding such as joining austenitic stainless steel to carbon steels for high temperature service, Ni-Cu alloys to carbon steel, Ni-Cu alloys to nickel-base alloys.	C Mn Si Cr Ni Fe Cu	0.10 3.0 0.5 20.0 72.0 1.3 0.01	550	30
Revofil 617	ERNiCrCoMo-1 ISO Ni6617	For welding of Alloy 617. Dissimilar joints involving high temperature applications. Examples are Alloy 600, Alloy 601, Alloy 800HT, Alloy 802 and cast alloys such as HK-40, HP and HP-45 Modified.	C Mn Si Cr Ni Fe Mo	0.08 1.0 0.6 23.0 Rem 2.5 8.5	620	25