

GEN 604 Welding Wire and Rod

GEN 604 is mainly used for GMAW and GTAW of base metals with similar chemical composition. It can also be used to join dissimilar metal combinations such as stainless steel, carbon steel and nickel base alloys.

CONFORMANCES

AWS A5.14	:	ERNiCrFe-5
ASME SFA-5.14	:	ERNiCrFe-5
UNS	:	N06062

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Nb+Ta	%Mn	%Fe
0.08 max	14.0 – 17.0	70.0 min	1.5 – 3.0	1.0 max	6.0 – 10.0
%Si	%P	%S	%Cu	%Co	Total Others
0.35 max	0.03 max	0.015 max	0.50 max	0.12 max	0.50 max

TYPICAL WELD METAL MECHANICAL PROPERTIES

Tensile Strength	:	80,000 psi	551 MPa
Yield Strength	:	40,000 psi	276 MPa
Elongation	:	30 %	

TYPICAL WELDING PARAMETERS*

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 18	90 – 130	100% Ar
	3/32"	2.4 mm	15 – 20	120 – 170	100% Ar
	1/8"	3.2 mm	15 – 20	150 – 220	100% Ar
MIG (GMAW)	.035"	0.9 mm	26 – 29	150 – 200	75% Ar – 25% He
	.045"	1.1 mm	28 – 32	180 – 220	75% Ar – 25% He

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED
BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

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