

AEROSPACE MATERIAL SPECIFICATION

Submitted for recognition as an American National Standard

NICKEL ALLOY, CORROSION AND HEAT RESISTANT, WELDING WIRE
50Ni - 20Cr - 20Co - 5.9Mo - 2.2Ti - 0.45Al
Consumable Electrode or Vacuum Induction Melted

UNS N07263

1. SCOPE:

1.1 Form:

This specification covers a corrosion and heat resistant nickel alloy in the form of welding wire.

1.2 Application:

This wire has been used typically as filler metal for gas-tungsten-arc or gas-metal-arc welding of corrosion and heat resistant nickel alloys of similar composition where the weld area is required to have strength and corrosion resistance comparable to those of the base metal, but usage is not limited to such applications.

2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2269	Chemical Check Analysis Limits, Nickel, Nickel Alloys, and Cobalt Alloys
AMS 2371	Quality Assurance Sampling and Testing, Corrosion and Heat Resistant Steels and Alloys, Wrought Products and Forging Stock
AMS 2813	Packaging and Marking of Packages of Welding Wire, Standard Method
AMS 2814	Packaging and Marking of Packages of Welding Wire, Premium Quality
AMS 2816	Identification, Welding Wire, Tab Marking Method
AMS 2819	Identification, Welding Wire, Direct Color Code System
ARP1876	Weldability Test for Weld Filler Metal Wire
ARP4926	Alloy Verification and Chemical Composition Inspection of Welding Wire

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2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM E 354 Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron, Nickel, and Cobalt Alloys

3. TECHNICAL REQUIREMENTS:

3.1 Wire Composition:

Shall conform to the percentages by weight shown in Table 1, determined by wet chemical methods in accordance with ASTM E 354, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - Composition

Element	min	max
Carbon	0.04	0.08
Manganese	--	0.60
Silicon	--	0.40
Phosphorus	--	0.015
Sulfur	--	0.007
Chromium	19.00	21.00
Cobalt	19.00	21.00
Molybdenum	5.60	6.10
Titanium	1.90	2.40
Aluminum	0.30	0.60
Titanium + Aluminum	2.40	2.80
Iron	--	0.70
Boron	--	0.005
Copper	--	0.20
Lead	--	0.002
Bismuth	--	0.0001
Silver	--	0.0005
Nickel	remainder	

3.1.1 Chemical analysis of initial ingot, bar, or rod stock before drawing is acceptable provided the processes used for drawing or rolling, annealing, and cleaning are controlled to ensure continued conformance to composition requirements.

3.1.2 Check Analysis: Composition variations shall meet the requirements of AMS 2269, No variation over maximum is permitted for lead, bismuth, and silver.

3.2 Melting Practice:

Alloy shall be produced by multiple melting using consumable electrode practice in the remelt cycle or shall be induction melted under vacuum. If consumable electrode melting is not performed in vacuum, electrodes which have been produced by vacuum induction melting shall be used.

3.3 Condition:

Cold worked, bright finish, in a temper and with a surface finish which will provide proper feeding of the wire in machine welding equipment.

3.4 Fabrication:

3.4.1 In-process annealing between cold rolling or drawing operations shall be performed in a protective atmosphere to avoid surface oxidation and adsorption of other extraneous elements.

3.4.2 Butt welding is permissible provided both ends to be joined are alloy verified using a method or methods capable of distinguishing the alloy from all other alloys processed within the facility or the repair is made at the wire processing station. The buff weld shall not interfere with uniform, uninterrupted feeding of the wire in machine welding equipment.

3.4.3 Drawing compounds, oxides, dirt, oil, and other foreign materials shall be removed by cleaning processes which will neither result in pitting nor cause gas absorption by the wire or deposition of substances harmful to welding operations.

3.5 Properties:

Wire shall conform to the following requirements:

3.5.1 Weldability: Melted wire shall flow smoothly and evenly during welding and shall produce acceptable welds. ARP1876 may be used to resolve disputes.

3.5.2 Spooled Wire: Shall conform to 3.5.2.1 and 3.5.2.2.

3.5.2.1 Cast: Wire, wound on standard 12-inch (305-mm) diameter spools, shall have imparted to it a curvature such that a specimen sufficient in length to form one loop with a 1-inch (25-mm) overlap, when cut from the spool and laid on a flat surface, shall form a circle 15 to 50 inches (381 to 1270 mm) in diameter.

3.5.2.2 Helix: The specimen on which cast was determined, when laid on a flat surface and measured between adjacent turns, shall show a vertical separation not greater than 1 inch (25 mm).

3.6 Quality:

Wire, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to welding operations, operation of welding equipment, or properties of the deposited weld metal.

3.7 Sizes and Tolerances:

Wire shall be supplied in the sizes and to the tolerances shown in 3.7.1 and 3.7.2.

3.7.1 Diameter: Shall be as shown in Table 2.

TABLE 2A - Sizes and Diameter Tolerances, Inch/Pound Units

Form	Nominal Diameter Inch	Tolerance Inch plus and minus
Cut Lengths	0.020, 0.025, 0.030, 0.035	0.001
Cut Lengths	0.045, 0.062, 0.094, 0.125	0.002
Spools	0.020, 0.025, 0.030, 0.035	0.001
Spools	0.045, 0.062, 0.094	0.002

TABLE 2B - Sizes and Diameter Tolerances, SI Units

Form	Nominal Diameter Millimeters	Tolerance Millimeters plus and minus
Cut Lengths	0.51, 0.64, 0.76, 0.89	0.025
Cut Lengths	1.14, 1.57, 2.39, 3.18	0.05
Spools	0.51, 0.64, 0.76, 0.89	0.025
Spools	1.14, 1.57, 2.39	0.05

3.7.2 Length: Cut lengths shall be furnished in 18, 27, or 36 inch (457, 686, or 914 mm) lengths, as ordered, and shall not vary more than +0, -0.5 inch (-13 mm) from the length ordered.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of wire shall supply all samples for vendor's test and shall be responsible for the performance of all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the wire conforms to specified requirements.