Inweld NA718

AWS A5.11 ERNiFeCr-2

Chemical Composition of Inweld NA 718

C	Mn	Fe	P	S	Si	Cu	Co	Al	Ti
0.08	0.35	Balance	0.015	0.015	0.35	0.30	---	0.20-0.80	0.65-1.15

Cr	Nb (Cb) +Ta	Mo	V	W	Other	Ni
17.0-21.0	4.75-5.50	2.80-3.30	---	---	0.5	50.0-55.0

Single values are maximum unless otherwise specified.

Description and Applications

Inweld NA718 is used for welding nickel-chromium-niobium-molybdenum alloy to itself using the GTAW process. The weld metal will age harden on heat treatment.

Procedure

Typical Weld Metal Properties

	AWS Spec (ksi)
Tensile Strength:	165,000
Yield Strength:	
Elongation:	

Recommended Parameters

GTAW

Wire Diameter	Voltage	Amperage