



UNITED STATES WELDING CORPORATION

USW ALLOY DESIGNATION AND DESCRIPTION	TURBALOY® 263 HQ-GRADE GTAW SOLID BARE WELDING WIRE NICKEL BASE		ISSUED JANUARY 2007		DATA SHEET 5966 (15)	
			REVISION NO. A			
CROSS-REFERENCE CONFORMANCE SPECIFICATIONS	MSRR 9500/16 AMS 5872 MSRR 7036 USWC 5872 (A) 48Ni 20Cr 20Co 5.9Mo 2.2Ti 0.45Al	ALLOY C-263 W No 2.4650 OMAT 3/62A UNS N07263 Available in MC-GRADE				
METALLURGICAL BACKGROUND INFORMATION	<p>TURBALOY® 263 undergoes a series of proprietary abrading and cleaning processes to remove all surface contaminants. These manufacturing processes ensure a consistent ultra-clean weld wire surface.</p> <p>TURBALOY® 263 is a Ni-Cr-Co-Mo precipitation hardening high temperature alloy used for welding similar turbine components.</p>					
MATERIALS TO BE WELDED AND APPLICATIONS	<p>Aircraft engine sheet components in Nimonic C263. BS HR10, HR 206, HR 404. AMS 5886. (Bars, forgings & rings)</p> <p>Pure argon gas shielding and ultra clean weldment preparation required.</p>					
WIRE CHEMISTRY WT%	Carbon	0.04	0.08	Cobalt	19.00	21.00
	Manganese	-	0.60	Titanium	1.90	2.40
	Silicon	-	0.40	Aluminum	0.30	0.60
	Sulfur	-	0.007	Ti+Al	2.40	2.80
	Phosphorus	-	0.015	Iron	-	0.70
	Chromium	19.00	21.00	Boron	-	0.005
	Molybdenum	5.60	6.10	Copper	-	0.20
				Nickel		Balance
WELD PROPERTIES	Hardness, soft condition: 20 HRC		Density: 8.36 gm/cc			
SIZES AND FORMS AVAILABLE	STRAIGHT LENGTHS			SPOOLED WIRE		
	5 lb. (2.2kg) packs 36" (914mm) lengths Flag tagged for traceability. (Double tagging and other lengths on request) Wide range of diameters.			Precision layer wound, with controlled cast and helix 12" (300mm) diameter spools standard 8" (200mm), 4" (100mm) and proprietary spool sizes on request. Wide range of diameters and spool weights.		
PACKAGING	Sealed polyethylene envelopes. (Desiccants optional)					

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