

VBC Alloy 0010 Jethete M190

Designation and Description	Jethete M190 GTAW Solid Welding Wire Iron Base	Issued: Mar/2014	MSRR: 9500/10	AMS: 5822D 5823E
		Revision: 01		
Cross Reference/ Conformance Specification	MSRR 9500/10 AMS 5822D AMS 5826E	OMat 3/54 UNS Number S41780		
Metallurgical Background Information	Jethete 190VM is produced by vacuum induction melting and re-melting techniques and the final wire is produced by special lubricant free, roller die forming followed by surface abrasion and cleaning processes. These manufacturing routes ensure consistent metallurgical integrity of the alloy with regard to control of trace elements and physical purity of the welding wire surface			
Materials To Be Welded, Applications and Advice	MSRR 6503, 6504, 6506, 6509, 6510, 6511, 6512, various form of Jethete. MSRR 6513, 6514, 6515, various forms of FV607 AMS 5719 Jethete M190 is used for the manufacture and repair of gas turbine components using GTAW and pure argon gas shielding.			
Wire Chemistry WT% (as per AMS)	Carbon – 0.10 – 0.15%	Molybdenum – 1.50 - 2.0%		
	Manganese - 0.40 - 1.30%	Cobalt – 1.3 – 2.0%		
	Silicon – 0.40% max	Vanadium – 0.25 – 0.40%		
	Sulphur – 0.008% max	Copper – 0.75% max		
	Phosphorous – 0.01% max	Nitrogen – 0.04% max		
	Chromium – 11.0 – 12.5%	Oxygen – 0.005% max		
	Nickel – 2.5-3.0%	Hydrogen – 0.001% max		
		Iron - Balance		
Weld Properties	Typical Hardness 299 – 344 HV			
Sizes and Forms of Supply	Straight Length: 2.5 kg Packs 36" / 914mm lengths 0.8mm – 3.2mm diameters Flag tagged (Double tagging and other lengths on request)	Spooled Wire: Precision layer wound with controlled cast and helix 300mm diameter standard 0.8mm – 2.4mm diameters		

Disclaimer: All information regarding our products is based on applied experience and extensive research work. We provide these technical data in good faith that they are accurate; this does not exempt the user from the obligation to check the information contained herein, especially if the application and process has not been expressly approved by us in writing. We make no guarantees or warranties (express or implied) about the contents of this datasheet. Any changes to processes must be approved by your organisations own quality department. VBC cannot be held responsible for any errors, omissions or inaccuracies published. We may change this datasheet from time to time without notice or obligation to the users. No part of this datasheet or any of its contents may be reproduced, copied, modified or adapted, without the prior written consent of VBC Group