

Applications

Electrode for all position welding of nickel, inconel, monel, nickel-iron– chromium alloys HK alloys, stainless And heat resisting steels. For use on equipment and components made of pure nickel, for fabrication of corrosion resistant tank and containers, heat exchangers, furnace components etc.

Characteristics on Usage

The Electrode gives soft stable arc on low currents. Deposits have excellent resistance to scaling at high temperatures and corrosion resistance at both normal and elevated temperatures.

Notes On Usage

- 1) Chip off base metal completely at the repairing part .
- 2) There is possibility that cracks spreads or makes holes at both ends of repairing part .
- 3) Keep the weld metal length less than 50 mm (2 inch) to disperse welding heat- adopt back stepping stone or symmetry method by turns.
- 4) The preheat temperature vary in accordance with the size, king and shape of the base metal 150°C is appropriate in general .

Welding Positions

1G 2F 3G 4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	Cu %
0.10 Max	1.0 – 3.50	0.75 Max	0.020 Max	0.030 Max	13.0 - 17.0	62.0 Min	0.5 -2.50	0.50 Max
Fe%	Nb (Cb)+ Ta %							
12.0 Max	0.5 – 3.0							

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
550 Min	30 % Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	DC (+)	40 - 60
3.15 x 350	2	10		60 - 80
4.00 x 350	2	10		100 - 140

Packing

Vaccum packing