

An advanced Nickel-Chromium-Molybdenum alloy electrode for resistance to severe corrosion and thermal cycling

Principal Applications

- Joining & cladding of high-strength, high heat and corrosion resistant Ni-based alloys of similar composition.
- Joining of high-tensile 5-9% Nickel Steels & Nitrogen-bearing Duplex Stainless Steels employed in chemical industry and sea water application.
- Dissimilar joining of above materials to ferritic, austenitic and mild / low alloy steels for applications demanding resistance to corrosion and thermal cycling.

Outstanding Features

- Excellent operating characteristics with easy slag removal.
- Fully alloyed core wire & special flux coating enables all position welding.
- Smooth, bright weld deposits are of radiographic quality.
- Confirms to ASME Sec II, Part C, SFA 5.11, Class ENiCrMo-3

Description

A new, basic coated Nickel alloy electrode designed specially for high temperature, corrosion resistant joining applications. Fully Austenitic, solid solution strengthened Nickel-Chromium-Molybdenum alloy deposit provides X-ray quality joints with good creep, fatigue and impact properties, along with excellent corrosion resistance. The weld deposit resists scaling in air upto 1100°C approx.

Technical Characteristics

Typical All-weld Chemistry (Wt %)

C	S	Mn	Si	Cr	Mo	Nb	Fe	Ni
0.025	0.01	0.30	0.48	21.3	9.3	3.6	0.8	Bal

Typical Mechanical Properties

Tensile Strength : 800 MPa
 Yield Strength : 620 MPa
 Elongation (L=4D) : 35%

Recommended Amperages

Size (mm)	2.50	3.15	4.00
Current (Amps)	45 - 70	70 - 100	90 - 130

Manufactured by :

EWAC ALLOYS LIMITED
 (An associate of Larsen & Toubro Limited)

Selling Agents :

Eutectic Products Division

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