

OK 92.26

Type Basic

SMAW

ENiCrFe-3

Description

A nickel-based electrode for welding nickel alloys such as Inconel 600 and similar Inconel alloys, cryogenic steels, martensitic to austenitic steels, dissimilar steels, heat-resistant steels and castings with limited weldability.

Welding current

DC+



Classifications

SFA/AWS A5.11	ENiCrFe-3
EN ISO 14172	E Ni 6182 (NiCr15Fe6Mn)

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Nb	Cu	Ti	Ta	Fe
0.03	0.5	6.6	15.8	67	1.7	<0.5	<0.5	<0.3	8.8

Typical mech. properties all weld metal

Yield stress, MPa	410
Tensile strength, MPa	640
Elongation A4, %	40

Charpy V

Test temps, °C	Impact values, J
+20	100
-196	80

Approvals

ABS	ENiCrFe-3
Sepros	UNA 409820
UDT	DIN 1736

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/electrode
2.5	300	45-70	22	0.63	88	0.9	50
3.2	350	70-105	23	0.62	57	1.2	60
4.0	350	90-130	24	0.64	31	2.0	60
5.0	350	120-170	25	0.64	20	2.7	68

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