

## AI-0315

### Specifications

**AWS/ASME** 11C SFA 5.11: ENiCrFe-2

**DIN** 1736: S-NiCr15FeNb

### Description and Applications

Basic coated electrode for welding Ni-base alloys, of the NiCr type, together or to stainless or mild steels. Also used for joining and cladding of various clad steels, 9% nickel alloys, cryogenic alloys and a wide range of other nickel alloys. Especially suited for welding of dissimilar combinations and thicknesses, particularly where heavy sections, crack sensitive designs and high or low temperature service is a feature. Maximum operating temperature approximately 850° C. Joining Ni alloyed steels used in the low temperature fields such as 9% Ni steel.

### Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe	Mo	Nb
0.08	2.80	0.40	15.00	Bal	8.50	1.70	1.70

### Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	650MPa
Yield Strength (0.2%)	400MPa
Elongation	35% (4d)
Charpy V	80J (-196° C)

### Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	50-70
3.2	DC /AC	70-95
4.0	DC /AC	90-120
5.0	DC /AC	120-160

### Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4F) Horizontal overhead position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

### Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

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