

AI-0316

Specifications

AWS/ASME 11C SFA 5.11 : ENiCrFe-3

DIN 1736: EL-NiCr15FeMn

Description and Applications

Basic coated electrode for welding Ni-base alloys such as alloy 600, 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.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe	Nb
0.02	7.1	0.30	14.70	Bal	7.50	2.00

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	630MPa
Yield Strength (0.2%)	370MPa
Elongation	38% (5d)
Charpy V	80J (-196° C)

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC +ve	45-70
3.2	DC +ve	65-105
4.0	DC +ve	85-135

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.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au

