

Classification : E-Ni6182–NiCr15Fe6Mn (ISO/EN 14172)

ENiCrFe-3 (AWS A5.11)

Properties :

Allied basic electrode, depositing an austenitic alloy of the Type Inconel 600. Used for the assembly and repair of Nickel alloys, pure Nickel, 5% Ni steels, cryogenic steels (up to 196 degrees Celsius and refractory, steels deemed difficult to weld, heterogeneous stainless steel/low-alloy or stainless-steel assemblies/ Nickel alloys. Crack-insensitive deposit, good resistance to acids, salts and alkaline solutions, molten salts (e.g. cyanides), oxidative atmospheres (Warning: avoid sulphurous atmospheres).

Applications :

Parts of ovens, burners, enclosures and thermal treatment tanks, cement plants (furnace and pebble bandages), part moulds, stripping tanks, transport and storage of liquid gases in the chemical and petrochemical industries, glassware, etc.

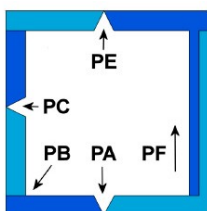
Mechanical characteristics :

Re > 380 MPa	Rm = 620 MPa	A6 > 35 %	KV > 80 J à 20°C
			KV > 65 J à – 196 °C

Packaging / Welding recommendations :

Ø mm	2,5	3,2	4
Poids étui (kg)	5	5	5
Intensité (A)	50 - 70	70 - 95	90 - 120

- Continuous current (+ at electrode).
- Welding joints must be clean and free of grease, cracks, etc.
- Weld by minimizing the amount of heat to eliminate the phenomenon of hot cracking. In the case of use on iron bases (high carbon steels) perform a preheating of the base metal (200 - 450 C depending on shade) in order to limit cracking in ZAT.
- Preheating



Welding positions :

Responsibility: The purpose of this document is to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for the applications for which it is intended. We reserve the right to modify the characteristics of its products without notice. Descriptions, illustrations and features are provided as an indication and cannot be the responsibility of our company. Smoke: View information on the Security Data Sheet available on request