

ES NiCrFe-2

Type Basic

SMAW
ENiCrFe-2

ESWECO
The Art of Welding

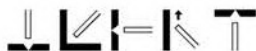
Description

ES NiCrFe-2 is a nickel-based electrode for welding Inconel 600 and similar alloys, cryogenic steels (e.g. 9Ni and 5Ni steels), martensitic to austenitic steels, dissimilar steels, heat-resistant steel castings with limited weldability and so on. The weldability is good in all positions, even in the over-head position.

Used extensively in the furnace equipment & repair / petro-chemical industries

Current

DC+



Classifications

SFA/AWS A5.11	ENiCrFe-2
EN ISO 14172	E Ni 6133 (NiCr16Fe12NbMo)

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Fe	Cu
<0.1	<0.75	2.3	15.0	70.0	1.5	2.0	9.0	<0.5

Typical mech. Properties all weld metal

Yield stress, MPa	420
Tensile strength, MPa	660
Elongation, A4 %	45

Charpy V

Test temps, °C	Impact values, J
+20	110
-196	90

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	50-85	22
3.2	350	70-105	23
4.0	350	100-140	24