

**Standards :**

**Chemical Composition of Weld Metal-  
% (Typical) :**

TS EN ISO 14172	: E-Ni 6620(NiCr14Mo7Fe)
EN ISO 14172	: E-Ni 6620(NiCr14Mo7Fe)
AWS A5.11	: E NiCrMo-6

C	Mn	Si	Mo	Ni	Fe	Cr	Nb	W
0.03	2.4	0.65	7.7	rest	9.0	16.5	1.7	1.4

**Mechanical Properties :**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>c</sub> =5d <sub>0</sub> )(%)
min. 350	min. 620	min. 50 J	min. 35

**Typical Base Material Grades :**

(G)X8Ni9, 12Ni19, ASTM A333, A334, A353, A522, A553

**Features and Applications :**

- \* Basic-character coating
- \* Applicability in joint-welding of low-temperature steels, stabilized or non-stabilized austenitic Cr-Ni(N) steels, cast steels, and heat-treatable cryogenic steels with 9% Nickel-content
- \* Toughness maintained at temperatures of up to -196 °C
- \* Linear type expansion coefficient of weld metal as similar to expansion of steels
- \* Usefulness at welding at difficult positions
- \* Requirement of re-drying at 300-350 °C for 2 hours

**Welding Positions :**



**Current Type :**

D.C.(+)

**Operating Data :**

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g/100 pcs
2.50 x 250	3/32 x 10"	50-80	1600
3.20 x 300	1/8 x 12"	75-105	2850
4.00 x 350	5/32 x 14"	90-130	5000

**Approvals :**

CE, GOST-R, SEPRO