

Standards :

Chemical Composition of Weld Metal-  
% (Typical) :

TS EN ISO 14172	:	E-Ni 6182(NiCr15Fe6Mn)
EN ISO 14172	:	E-Ni 6182(NiCr15Fe6Mn)
AWS A5.11	:	ENiCrFe3

C	Mn	Si	Ni	Fe	Cr	Nb
0.04	7.5	0.60	rest	7.5	16.7	2.2

Mechanical Properties :

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength		Elongation (L <sub>0</sub> =5d <sub>0</sub> )(%)
		(ISO-V/+20°C)	(ISO-V/-196°C)	
min. 360	min. 550	min. 47 J	min. 32 J	min. 30

Typical Base Material Grades :

NiCr 15 Fe, LC-NiCr 15 Fe, NiCr 60 15, INCONEL 600/600L, INCOLOY 800

Features and Applications :

- \* Nickel-based basic-type electrode
- \* Applicability in welding high-temperature steels and low-temperature alloyed or unalloyed steels, nickel (Ni), and Ni-alloys
- \* High creep-resistance
- \* Serviceability at temperatures ranging between -190 °C and 480 °C
- \* 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