

NICALLOY Fe-2

AWS A/SFA 5.11 ENiCrFe-2

NON FERROUS (Ni Alloys)

CLASSIFICATION:

ISO 14172

E Ni 6133 (NiCr16Fe12NbMo)

IS 8736

E NiCrFe-2

KEY FEATURES:

- Basic type coating
- Ni-Cr-Fe type deposit
- Ductile weld resistant to cracking
- Outstanding strength and resistance to oxidation at high temperature
- Application from cryogenic to 820°C
- Resistant to embrittlement and creep at high temperatures upto 820°C
- Versatile product for dissimilar joining
- Positional welding capability
- For overlay applications minimum three layers must be deposited

APPROVALS: IBR/CE

TYPICAL APPLICATIONS:

- Welding of wrought and cast form of Ni-Cr-Fe alloys
- Joining carbon, SS or low alloy steel or combinations of any of them
- Welding of ASTM E163/166/167/168, Alloy 600/601
- Joining Ni based alloys to steel
- Fabrication of Corrosion resistant tanks, Furnace components
- Applications in Refineries, Foundries, Heat exchanger, Pressure vessel manufacturing, Chemical plants



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni	Cr	Nb+Ta	Mo
0.025	3.25	0.5	2.9	72.5	16.5	1.9	1.35

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	550 min	30 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	45 - 70	 DCEP	All Positions, except vertical Downwards
3.15 x 350	80 - 100		
4.0 x 350	90 - 130		
		REDRYING CONDITION: 250-300°C for minimum 1 hr.	

Available in Ivory packing of 10 kg box containing 10 cartons of 1 kg each.