



## NICALLOY Fe-2

NON FERROUS (Ni Alloys)



Nickel based Electrode for high oxidation resistance

**CLASSIFICATION : ISO 14172**

**AWS A/SFA 5.11**

E Ni 6133 (NiCr16Fe12NbMo)

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

### WELDING POSITION :



**DCEP**

### 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

**REDRYING CONDITION : 250-300°C for minimum 1 hr.**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Ni</b>	<b>Fe</b>	<b>Mo</b>
Specification	0.10 max	1.0 to 3.5	0.75 max	62.0 min	12.0 max	0.5 to 2.5
	<b>S</b>	<b>P</b>	<b>Cu</b>	<b>Cr</b>	<b>Nb plus Ta</b>	<b>Other</b>
Specification	0.02 max	0.03 max	0.50 max	13.0 to 17.0	0.5 to 3.0	0.50 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>EL%</b>
Specification	As Welded	550 min	30 min

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton, Kg</b>	<b>Cartons/Box</b>	<b>Net wt./Box, Kg</b>
2.5 x 350	45 - 70	1	10	10
3.15 x 350	80 - 100	1	10	10
4.0 x 350	90 - 130	1	10	10