



# NICALLOY Fe-3

NON FERROUS (Ni Alloys)

AWS A/SFA 5.11 ENiCrFe-3

### CLASSIFICATION:

ISO 14172

E Ni 6182 (NiCr15Fe6Mn)

IS 8736

E NiCrFe-3

### KEY FEATURES:

- Basic type coating
- Ni-Cr-Fe type deposit
- Ductile weld resistant to thermal shocks and hot cracking
- Outstanding strength and resistance to corrosion from normal to high temperatures
- Application from cryogenic to 480°C
- 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 to themselves and to carbon steels
- Joining carbon, SS or low alloy steel or combinations of any of them
- Welding of ASTM E163/166/167/168, Inconel 600 and similar nickel alloys
- Joining Ni based alloys to steel
- Fabrication of Corrosion resistant tanks, Furnace components
- Applications in Refineries, Foundries, Heat exchanger, Pressure vessel manufacturing, Chemical plants


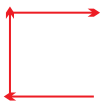
### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni	Ti	Cr	Nb+Ta
0.02	5.5	0.6	5.8	70	0.05	14.5	2.1

### MECHANICAL PROPERTIES OF ALL WELD METAL:

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

### PARAMETERS - PACKING DATA:

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

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