



NICALLOY Fe-3

NON FERROUS (Ni Alloys)



Basic coated Nickel based Electrode for inconel alloy Welding

CLASSIFICATION : ISO 14172

AWS A/SFA 5.11

E Ni 6182 (NiCr15Fe6Mn)

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

WELDING POSITION :



DCEP

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
- Welding in harsh, corrosive condition e.g. desalination, petrochemical and power generation plants
- Application in temperature critical conditions such as furnace equipment and pipe work

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Ni	Fe	Ti
Specification	0.10 max	5.0 to 9.5	1.0 max	59.0 min	10.0 max	1 max
	S	P	Cu	Cr	Nb plus Ta	Other
Specification	0.015 max	0.03 max	0.50 max	13.0 to 17.0	1.0 to 2.5	0.50 max

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	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
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