NICALLOY Mo-12

NON FERROUS (Ni Alloys)

AWS A/SFA 5.11 **ENiCrMo-12**

CLASSIFICATION:

ISO 14172
E Ni 6627 (NiCr21MoFeNb)

KEY FEATURES:

- Basic coated electrode
- Weld metal is highly resistant to hot cracking, stress corrosion cracking and thermal shock
- Works smoothly with negligible spatter
- Reduces carbon diffusion at high temperature
- Recommended for high temperature and creep resisting steels

APPROVALS: CE

TYPICAL APPLICATIONS:

- Joining materials of the same nature, e.g. material 2.4602 (NiCr21Mo14W) and these materials with low alloyed steels such as for surfacing on low alloy steels
- Welding components in chemical processes handling highly corrosive media
- Dissimilar joints between Ni-Cr-Mo alloys and stainless, carbon or low alloy steels
- Overlay cladding on carbon, low alloy and stainless steels
- Digesters and paper making equipment, Scrubbers for flue gas desulphurization

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni	Nb+Ta	Mo
0.017	2.0	0.5	66.5	20.9	1.6	9.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	650 min	35 min

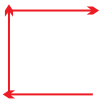
PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A
2.5 x 350	45 - 70
3.15 x 350	80 - 100
4.0 x 350	90 - 130

AC (70 OCV)/DCEP

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

All Positions, except vertical Down



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