



NICALLOY Mo-12

NON FERROUS (Ni Alloys)



Nickel base Electrode for application from cryogenic to elevated temperature

CLASSIFICATION : ISO 14172

AWS A/SFA 5.11

E Ni 6627 (NiCr21MoFeNb)

E NiCrMo-12

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

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Joining Cr-Ni-Mo austenitic steel to duplex stainless steels and 9% Ni steel for cryogenic applications, forging dies for service applications from -200°C to 1000°C
- High grade welding of high Mo Nickel base alloys e.g. Inconel 625/800 as well as Cr-Ni-Mo steels with high Mo content
- Joining of A 240, A 107, A 182, A 249, A 276, A 312, A 358, A 473

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Fe	S	P	Si
Specification	0.03 max	2.2 max	5.0 max	0.02 max	0.03 max	0.7 max
	Cu	Cr	Nb+Ta	Mo	Ni	Other
Specification	0.50 max	20.5-22.5	1.0-2.8	8.8-10.0	Rem.	0.50 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	CVN Impact at -196°C, J	Lateral Expansion, mils
Specification	As Welded	650 min	35 min	35-60	30-50

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