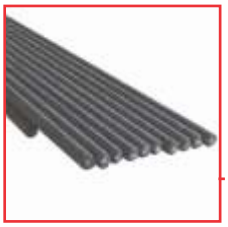

NICALLOY Mo-6

NON FERROUS (Ni Alloys)

Nickel based Electrode for LNG storage systems

CLASSIFICATION : ISO 14172	AWS A/SFA 5.11
E Ni 6620 (NiCr14Mo7Fe)	E NiCrMo-6

KEY FEATURES :

- Basic coated electrode
- Weld metal is highly resistant to hot cracking, stress corrosion cracking and thermal shock
- Recommended for low temperature and cryogenic steels like 9% Ni steels
- Carbon diffusion at high temperature during heat treatment of dissimilar joints is largely reduced
- Weld metal meets highest quality requirements
- Good performance on AC and DC

WELDING POSITION : 

AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Joining 9% Nickel steel for cryogenic applications, especially LNG storage systems
- Welding of ASTM SA 553 Class 1 and SA 353 Class 1 steels
- High grade welding of high Mo nickel base alloys as well as Cr-Ni-Mo steels with high Mo content
- Joining Ni base alloys to steel, stainless/ heat resistant cryogenic steels and alloys

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Fe	S	P	Si	Other
Specification	0.10 max	2.0 to 4.0	10.0 max	0.02 max	0.04 max	1.0 max	0.50 max
	Cu	**Nb plus Ta**	**Cr**	**Mo**	**W**	**Ni**	
Specification	0.50 max	0.5 to 2.0	12.0 to 17.0	5.0 to 9.0	1.0 to 2.0	55.0 min	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	CVN Impact at -196°C, J	Lateral Expansion, mm
Specification	As Welded	620 min	35 min	50 min	0.50 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