

Standards

AWS A5.11 : ~E NiCrFe-3

Mechanical Properties

| Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Elongation ((L ₀ =5d ₀) (%)) | Impact Strength (ISO-V/+20°C) | Impact Strength (ISO-V/-196°C) |
|--|--|--|----------------------------------|-----------------------------------|
| min. 380 | 550 | min. 30 | min. 70J | min. 50J |

Features and Applications

- Nickel based basic type electrode
- Applicability in welding high-temperature steels and low-temperature alloyed or unalloyed steels, Nickel & Ni-alloys, casting steels
- Also include cement kiln rings, blast furnace components, chemical containers and liquid gas installations
- Used for the materials which are difficult to welding
- Electrode has a stabil arc
- The weld metal is resistant to cracking (cracking test results are suitable)
- Weldability in all position especially for vertical upward position (PF)

Welding Positions



Current Type

D.C.(+)

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | Welding Current (A) | Package Weight (Kg) | Weight g / 100 pcs |
|--------------|------------------------------------|------------------------|------------------------|-----------------------|
| 3030100025 | 2.50 x 250 | 70 - 100 | 5 | 2640 |
| 3030100026 | 3.20 x 300 | 80 - 130 | 5 | 4620 |
| 3030100029 | 4.00 x 350 | 130 - 160 | 5 | 5420 |

Approvals: GOST-R, SEPRO