Nickel Based Electrode
NIBAZ B 71

Standards

TS EN ISO 14172	: E Ni 6182 (NiCr15Fe6Mn)
EN ISO 14172	: E Ni 6182(NiCr15Fe6Mn)
AWSA5.11	: E NiCrFe3

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Ni	Fe	Cr	Nb
0.04	7.5	0.6	rest	7.5	16.7	2.2

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Impact Strength (ISO-V/-196°C)	Elongation ($L_o=5d_o$) (%))
min. 360	min. 550	min. 47 J	min. 32 J	min. 30

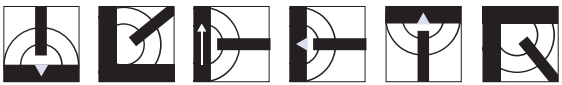
Typical Base Material Grades

- NiCr 15 Fe, LC-NiCr 15 Fe, NiCr 60 15,INCONEL 600/600L, INCOLOY 800

Features and Applications

- This electrode is a Nickel-based and basic-type electrode
- Applicability in weldinghigh-temperature steels and low-temperature alloyed or unalloyed steels, Nickel (Ni), and Ni-alloys
- High creep-resistance
- Serviceability at temperatures ranging between -196°C and 480°C
- Requirement of re-drying at 300°C-350°C for 2 hours

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm)	(inch)	Welding Current (A)	Weight g / 100 pcs
3010102031	2.50 x 250	3/32 x 10”	50 - 80	1600
3010102036	3.20 x 300	1/8 x 12”	75 - 105	3250
3010102041	4.00 x 350	5/32 x 14”	90 - 130	5490

Approvals: SEPRO