

### Standards

AWS A5.11 : ~E NiCrFe-3

### Mechanical Properties

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	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 350	70 - 100	5	2640
3030100026	3.20 x 300	80 - 130	5	4620
3030100029	4.00 x 350	130 - 160	5	5420

Approvals: SEPRO