

## R- INCONOLY 825

**Nickel-Iron-Chromium alloy basic flux coated electrode used for primarily Inconel 825**

**CLASSIFICATION** : Inconel 825 (Nearest)

**DESCRIPTION:** Nickel-Iron-Chromium alloy basic flux coated electrode used for primarily Inconel 825 to itself or other similar base metals such as nickel-iron-chromium-molybdenum-copper alloys, the weld metal is highly corrosion resistant mainly in reducing chemical like sulphuric and phosphoric acids, it can also use to overly cladding for alloys,

**APPLICATION:** Ideally suited for welding of pressure vessels, heat exchangers, cast pumps, valves and others components,

**RE-DRY CONDITION** : Re-Dry the electrode at 350°C for 1 hrs before use.

### TYPICAL ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.050	1.00- 2.50	0.50	0.020	0.030	19.50- 23.50	38.00- 46.00	2.50- 3.50	1.50- 3.00

Single value are maximum

### TYPICAL ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm <sup>2</sup> )	ELONGATION %
550 Min.	25 Min

### DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+) Amps	Kg/Package	Kg/case.
2.50/2.40	3/32"	60-80	2	10
3.15 / 3.20	1/8"	80-120	2	10
4.00	5/32"	110-160	2	10
5.00	3/16"	150-200	2	10

Customer packing on request.