

RATNABNi65

Specially designed a high Nickel alloy electrode.

CLASSIFICATION : AWS/SFA-5.11: E NiCr Fe-2

APPROVAL :

CHARACTERISTICS : A high Nickel alloy electrode specially designed to resist crack, oxidation and corrosion. Equally provides high strength at elevated temperature. Gives smooth arc, excellent operating characteristics, easy slag detachability.

APPLICATION :

- 1) Suitable to weld dissimilar metals viz carbon steel, stainless steel, Ni and Ni based alloy.
- 2) Base materials : Inconel 600, Incoloy 800, Incoloy DS
- 3) Cryogenic vessels & pipe work of 3-9 % Ni steels for temperatures down to -196°C
- 4) Elevated temperatures services in furnace equipment & petrochemical plants involving temperatures upto 1000°C
- 5) Joining and Surfacing in fabrications.

RE-DRY CONDITION : Re-Dry the electrode at 250°C for 1 hour before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Cr	Mo	Fe	Cb
0.10 max.	1.00- 3.50	0.75 max	62.00 Min	13.0 17.0	0.50- 2.5	12.00 Max	0.50- 3.00

WELD METAL MECHANICAL PROPERTIES :

UTS N/mm ²	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
550 Min.	30 Min.	-196 ⁰ C : 50 J Min.

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+) Amps	Wt. of /pkt.	Wt. of Case
2.50/ 2.40 X 350	3/ 32" X 14"	60-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	70-100	2	20
4.00 X 350	5/ 32" X 14"	100-130	2	20
5.00 X 350	3/ 16" X 14"	150-190	2	20

Customer packing on request.