

RATNABNi70

Nickel-base alloy basic coated electrode for yielding weld deposition.

CLASSIFICATION : AWS/SFA-5.11: E NiCr Fe-3

APPROVAL :

CHARACTERISTICS : A basic coated Ni alloy electrode producing inconel weld deposit. Electrode exhibits excellent results while welding 5 & 9 % Ni steels, inconel steels under low temperature applications, produces crack free joints which are resistant to oxidation and corrosion.

APPLICATION :

- 1) Suitable to Nickel and Nickel based alloy.
- 2) Inconel 600, Nimonic 75, Monel 400 to themselves or to mild steel, low steel and stainless steels.
- 3) Low temperatures applications such as 5% & 9 % steels used for Cryogenic vessels & pipe work for temperatures down to -100°C
- 4) furnace equipment & petrochemical plants.
- 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	Ti	Fe	Cb
0.08 max.	5.00- 9.50	0.75 max	59.00 Min	13.0 17.0	1.00 Max.	10.00 Max	1.00- 2.50

WELD METAL MECHANICAL PROPERTIES :

UTS N/mm ²	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
550-640	30 -40	-196 ⁰ C : 60-90 J

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.



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