

RATNABNi 80

Nickel-base NiCrMoalloy super austenitic stainless steels Electrode.

CLASSIFICATION : AWS/SFA-5.11: E NiCr Mo-3
UNS No. W86112

APPROVAL :

CHARACTERISTICS : standardized with coating of special basic flux system, pleasing behavior in terms of smooth arc, low spatter and easy de-slagging. Weld metal gives of radiographic quality.

APPLICATION :

Highly versatile, nickel-base alloy electrode suitable for a wide range of applications :-

- 1) Cryogenic vessels & pipe work of 9% Ni steel (Q&T grade) for temperatures down to -196°C.
- 2) Elevated temperature services in furnace equipment and petrochemical plants & power generation plants, involving temperatures above 900°C.
- 3) Repair & Maintenance welding, especially in reclamation of dies.
- 4) Base Materials : Inconel 625, Inconel 601, Incoloy 800H, 825, & Similar.

RE-DRY CONDITION : Re-Dry the electrode at 300°C for 2 hour before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Cr	Mo	Fe	Cb
0.10 max.	1.00 max.	0.75 max	55.00 Min	20.50- 23.0	8.00- 10.00	7.00 Max	3.15- 4.15

WELD METAL MECHANICAL PROPERTIES :

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