RATNA B Ni 90

A Chemically Basic Flux coated Nickel Based Alloy High in Both Cr and Mo.

CLASSIFICATION : AWS/SFA-5.11: E NiCr Mo-6
BS EN ISO 14172

CHARACTERISTICS : Basic coated special welding electrode with high Nickel, Chromium and Molybdenum core wire. The electrode suitable for use on DC+ and welding with smooth Arc and Great arc stability and thus easy control of weld pool with good slag detachability,

APPLICATION : 1) As the weld metal has given excellent cryogenic properties, both toughness and lateral expansion,
2) Cryogenic vessels & pipe work of 9% Ni steel for temperatures down to -196°C.
3) Suitable for ASTM A353, A533, UNS k81340 and K71340.
4) Also suitable for 5% Nickel steel including ASTM A645 and A352 LC4 (cast.)

RE-DRY CONDITION : Re-Dry the electrode at 350°C for 2 hour before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Cr	Mo	Fe	Cb	W
0.10 max.	2.00 4.00	1.00 max	55.00 Min	12.0 17.0	5.00-9.00.	10.00 Max	0.50-2.00	1.00-2.00

WELD METAL MECHANICAL PROPERTIES :

UTS N/mm2	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
620 Min.	35 Min	-196^0C : 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	3/ 32"	60-80	2	20
3.20	1/ 8"	90-103	2	20
4.00	5/ 32"	110-160	2	20
5.00	3/ 16"	150-200	2	20

Customer packing on request.