



GB/T 13814 ENi 6182

AWS A5.11 ENiCrFe-3

EN ISO 14172- ENi 6182

AK ENiCrFe-3

Description: Low hydrogen type of manual electrode, with nominal composition 65%Ni-15%Cr-8%Fe-7.5%Mn-2%Nb+Ta-1.5%Mo.is Ni-Cr-Fe alloy manual electrode; Has higher high temperature strength and oxidation resistance due to the higher alloy content,and can adjust a range from low temperature to 480C; Stable arc, beautiful weld bead appearance, few spatter. easy slag removal,excellent blowhole resistance,and stable deposited metal mechanical properties.

Application: Suitable for the welding of Ni-Cr-Fe series alloy,such as Inconel 600. and similar alloy; Can also be used for buildup welding on the surface of steel when extra Mn content is harmless in the application in use;Can be used for dissimilar welding between steel and other nickel alloy.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Fe	Ni	Cr	Nb +Ti
Requirement	0.10	1.00	5.00-9.50	0.015	0.03	10.00	≥ 59	13.0-17.0	1.0-2.5
Actual Result	0.046	0.45	7.60	0.005	0.009	3.56	69.4	15.70	1.76

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 550	≥ 360	30	
Actual Result	650	410	40	