

# TALARC NiCrMo

## CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.5: E10018M	EN 757: E 62 4 1NiMo B 4 2 H5

## ALLOY TYPE

Basic-coated electrode for welding high strength steels.

## APPLICATIONS

Low-alloy basic-coated electrode with Ni-Cr-Mo additions designed for welding high yield strength steels with minimum tensile strength higher than 690 MPa. Good impact strength at low temperatures. Suitable for the metal working industry, offshore fabrication, chemical and petrochemical industry. It also has applications in fabrications of HSLA (high-strength low-alloy) steels, which may be used for industrial machinery construction, cranes and other highly stressed structural components.

## TYPICAL CHEMICAL COMPOSITION OF WELD METAL

C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Mo %
0.05	1.30	0.40	0.025	0.025	-	1.30	0.30	0.40

## TYPICAL MECHANICAL PROPERTIES

	Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
	Rs	Rm	A 5d	0°C	-20°C	-30°C	-40°C	-60°C
	(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
as welded	660	750	22	-	90	-	60	-

## WELDING GUIDELINES

Preheat and interpass temperature 100°C. PWHT is not required. To obtain the best mechanical properties results, the use with low heat input is advised (follow the steel producer recommendations). To be reconditioned at 370÷400°C for an hour (max 3 times) if necessary.

## TECHNICAL INFORMATION

Welding positions: all positions, except vertical down



## WELDING PARAMETERS

Current	AC / DC + Reverse polarity		
Diameter (mm)		3.2	
Length (mm)		350	
Current (A)		90 ÷ 140	

Diam.	Pack/Carton	Part No.
3.2mm	2kg VAC pack/12kg	INE80B32

TALARC Pty Ltd  
10-16 Syme St  
Brunswick, Vic 3056  
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710  
W: [www.talarc.com](http://www.talarc.com) E: [sales@talarc.com](mailto:sales@talarc.com)