

Ni-Cr-Fe Welding Electrode

INCO-WELD® A Welding Electrode

INCO-WELD A Welding Electrode is used for shielded-metal-arc welding of INCOLOY alloys 800 and 800HT, INCONEL alloys 600 and 601, and nickel steels. The weld metal has excellent strength and oxidation resistance at high temperatures and retains impact resistance at cryogenic temperatures. The electrode is an exceptionally versatile product for dissimilar welding. It can be used on a variety of austenitic and ferritic steels and nickel alloys. Examples are combinations of stainless steels, carbon steels, INCONEL alloys, INCOLOY alloys, MONEL alloys, and copper-nickel alloys. Because of its versatility, INCO-WELD A Welding Electrode is especially useful for general maintenance welding of equipment exposed to strenuous service conditions.

The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive.

Specifications

AWS A5.11 ENiCrFe-2 (UNS W86133)
ASME II, Part C, SFA-5.11, ENiCrFe-2 (UNS W86133)
ASME IX, F-No.43
*DIN 1736 EL-NiCr15FeNb (2.4805)
*(EN) ISO 14172 – ENi6092 (NiCr16Fe9NbMo)
*Supply to these specifications available upon request
For manufacture to ASME III (NCA3800, NB2400), MIL and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

VdTUV 2104.00
Other approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition	Ni+Co..... 62.0 min.		Cu..... 0.50 max.	
	C	0.10 max.	Cr	13.0-17.0
Mn.....	1.0-3.5	Nb+Ta	0.5-3.0	
Fe.....	12.0 max.	Mo.....	0.5-2.5	
S	0.02 max.	P	0.03 max.	
Si	0.75 max.	Others	0.50 max.	

Minimum Mechanical Properties	Tensile Strength, psi		80,000
		MPa	552
	Elongation, (4d) %	30	

Available Product Forms – Supplied in 10lbs (4.54kg) hermetically sealed containers

Diameter	mm	2.4	3.2		
Length	mm	229	356		
Current (DC+)	A	45-70	65-95		

Rod Diam.	4.54 kg Pack
2.4mm	SMEINCOA24
3.2mm	SMEINCOA32

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