

NICROWELD 70/20

Electrodes MMA [SMAW]

Nickel alloys

CLASSIFICATION: EN ISO 14172-A : E Ni 6082 (NiCr20Mn3Nb) DIN 1736 : EL NiCr19Nb AWS A-5.11 : E NiCrFe-2	APPROVALS:	APPLICATION: Hardfacing and repairing Constructions & Engineering Petrochemical and chemical industry
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- Basic coated special electrode with an alloyed core.
- For joining and cladding low-alloy and high-alloy steels as well as nickel alloys and dissimilar joints.
- The austenitic weld is resistant to hot cracking and is ductile at both low and high temperatures.
- Non-scaling up to 1000°C and to low temperatures down to -196°C
- Pre heat treatment: if required for base material.

Application

Chemical and petrochemical industries, power industry, steelworks and glassworks, repairing and maintenance.

Base material

Alloy	W.Nr.
600	2.4816
600L	2.4817
800H	1.4876
Joining copper with stainless steel	
Low-alloy steels, working at elevated temperatures, creep-resistant, working at low temperatures	
High-alloy Cr and CrNi steels, especially for joining dissimilar steels, nickel alloys and nickel-steel combinations	

Typical chemical composition %

C	Mn	Cr	Ni	Mo	Nb	Fe
0,04	<4,5	19,0	base	1,0	2,0	<4,0

Typical mechanical properties

Yield strength Re [N/mm ²]	>420
Tensile strength Rm [N/mm ²]	>700
Elongation A5 [%]	>42
Impact energy Kv [J]	>96 J (-196°C) /
Coating type	basic
Welding current	
Welding positions	

Redrying	350°C / 1h
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Welding parameters and packing

∅	Length [mm]	Welding current [A]
2,5	300 /	50-90
3,2	350 /	70-110
4,0	350 /	100-160

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