

## Conformances

AWS A5.11/ ASME SFA5.11 ENiCrFe-3  
 JIS Z3224 DNiCrFe-3  
 EN ISO 14172 Ni 6182  
 CE

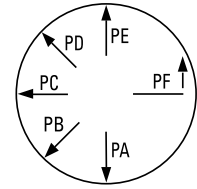
## Applications

- Inconel 600, 601 and stainless steels & low-alloy steel & nickel-alloy steel.
- Ni-Cr-Fe alloy clad steels

## Features

- Good crack resistance
- Good arc stability and good slag removal
- Good bead appearance

## Welding Position



## Current

DC +

## Diameter / Packaging

Diameter mm (in)	Length mm(in)	
	300 (12)	350 (14)
2.6 (3/32)	✓	
3.2 (1/8)		✓
4.0 (5/32)		✓
5.0 (3/16)		✓

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ti	Nb+Ta	Fe	Ni
0.06	0.46	6.5	0.011	0.010	16.3	0.07	1.8	5.2	72.0

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.lbs)
-	650 (94,000)	40.0	-196 (-321)	76 (56)

## Typical Welding Parameters

Diameter	Approx. Current (Amps)			
	2.6mm (3/32) DC +	3.2mm (1/8) DC +	4.0mm (5/32) DC +	5.0mm (3/16) DC +
F&HF	60~90	70~115	100~140	120~160
V-up	60~90	65~110	100~130	110~140