

JACKSUN ALLOY NI 70

ELECTRODES ARE USED FOR THE WELDING OF NICKEL-CHROMIUM-IRON ALLOYS TO THEMSELVES AND FOR DISSIMILAR WELDING

BASIC ALLOY: MN, NI, CR, NB,
AWS/SFA-5.11: ENICRFE-3
EN ISO 14172 E NI 6182
(NICR15FE6MN)

KEY FEATURES:

ROWELD B Ni70 electrodes are used for the welding of nickel-chromium-iron alloys to themselves and for dissimilar welding between nickel-chromium-iron alloys and steels. Its high manganese content lessens the possibility of micro fissures and also reduces creep strength which limits its usage to 900°F.

APPLICATIONS

- Applications for this alloy include surfacing as well as clad-side welding.
- Welding Suitable for desalination plants, petrochemical facilities and power generation plants.
- Low temperatures applications such as 5% & 9 % steels used for Cryogenic vessels & pipe work for temperatures down to -100°C

RE-DRY CONDITION:

- Re-Dry the electrode at 350C for 1 hrs. before use.

CHEMICAL COMPOSITION:

C	Mn	Si	Ni	Ti	Cr	Fe	Nb
0.80 max.	5.00-9.50	0.75 Max	59.00 Min.	1.00 max	13.00-17.00	10.00 Max.	1.00-2.50

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @
450 Min	550 Min.	30 Min.	- 196C : 50 J Min.

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+ / AC) Amps	Kg/pkt.	Kg/Case
2.50 / 2.40	3 / 32"	60-80	2	10
3.15 / 3.20	1 / 8"	90-120	2	10
4.00	5 / 32"	110-160	2	10
5.00	3 / 16"	150-180	2	10