

JACKSUN ALLOY NI 80

NICKEL-BASED NICKEL-MOLYBDENUM SUPER AUSTENITIC
STAINLESS STEELS ELECTRODE.

BASIC ALLOY: NI, CR, NB, MO

AWS/SFA-5.11: ENICRMO-3

EN ISO 14172 E NI 6625

(NICKEL22MO9NB) UNS NO. W86112

KEY FEATURES:

ENiCrMo-3 is Balanced formulated special basic flux system, pleasing behavior in terms of smooth arc, low spatter and easy de-slagging. Weld metal gives of radiographic quality.

APPLICATIONS

- Cryogenic vessels & pipe work of 9% Ni steel (Q&T grade) for temperatures down to -196°C.
- Repair & Maintenance welding, especially in reclamation of dies.
- Elevated temperature services in furnace equipment and petrochemical plants & power generation plants, involving temperatures above 900°C

RE-DRY CONDITION:

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

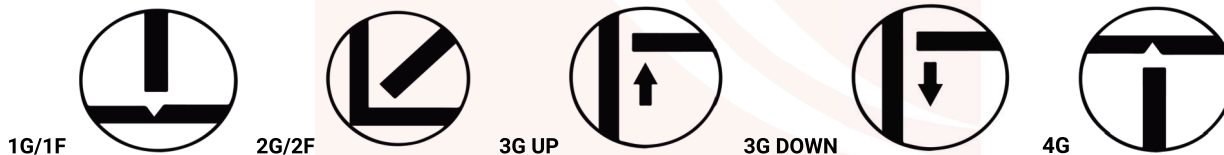
CHEMICAL COMPOSITION:

C	Mn	Si	Ni	Mo	Cr	Fe	Nb
0.10 max.	1.00 Max	0.75 Max	55.00 Min.	8.00-10.00	20.50-23.00	7.00 Max.	3.15-4.15

MECHANICAL PROPERTIES:

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