



D&H 1212(MOD)



Codification :

AWS SFA 5.11	ENiCrFe-3 (Approx)
EN ISO 14172	ENi6082



Characteristics & Applications :

Electrode is depositing 65%Ni-20%Cr-2%Nb-1.5%Mo weld metal. Radiographic quality weld metal of superior properties. It is ideally suited for welding alloys of similar compositions to themselves, for surfacing steel with Nickel-Chromium-Iron alloy when high Manganese contents are not detrimental, for welding clad side of Nickel Chromium-Iron clad steel and dissimilar metal combinations. Suitable for overlay of forge plates. Specially recommended for welding 9%Ni Steels for cryogenic service. Also used for welding of Nickel-Chromium alloys used for high temperature applications like furnace heating elements and reformer tubes.

Typical Chemical Composition Of All Weld Metal (%) :

Element	C	Mn	Si	Cr	Ni	Mo	Fe	Nb	Cu	Ti
Typical	0.04	4.0	0.50	20.0	Bal	1.5	3.0	2.0	0.30	0.30

Typical Mechanical Properties Of All Weld Metal :

Properties	UTS (MPa)	YS (MPa)	%El (L=5d)	CVN Impact Strength (J) -196°C	Lateral Expansion (mm) -196°C	Creep Strength MPa 600°C for 1000 hrs
Typical	620	500	30	75	0.85	160

Welding Positions :



Current And Packing Data: DC(+)

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	150-180	120-150	80-110	60-70
Weight/Carton (kgs)	2.5	2.5	2.5	2.5

Approvals : BHEL, CE

Precautions :

1. Ensure the electrodes are dry. Re-dry the electrodes at 300-325°C for 1 hour.
2. Maintain a short arc, stringer bead and minimize the heat input.
3. Allow the weld to cool down to below 50°C before depositing, the next layer.