



NICALLOY Mo-6

NON FERROUS (Ni Alloys)

AWS A/SFA 5.11 ENiCrMo-6

CLASSIFICATION:

ISO 14172

E Ni 6620 (NiCr14Mo7Fe)

IS 8736

E NiCrMo-6

KEY FEATURES:

- Basic coated electrode
- Weld metal is highly resistant to hot cracking, stress corrosion cracking and thermal shock
- Recommended for low temperature and cryogenic steels like 9% Ni steels
- Carbon diffusion at high temperature during heat treatment of dissimilar joints is largely reduced
- Weld metal meets highest quality requirements
- Good performance on AC and DC

APPROVALS: CE

TYPICAL APPLICATIONS:

- Joining 9% Nickel steel for cryogenic applications, especially LNG storage systems
- Welding of ASTM SA 553 Class 1 and SA 353 Class 1 steels
- High grade welding of high Mo nickel base alloys as well as Cr-Ni-Mo steels with high Mo content
- Joining Ni base alloys to steel, stainless/ heat resistant cryogenic steels and alloys


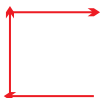
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Ni	Cr	Nb+Ta	W
0.025	3.0	0.6	60	15.7	1.3	1.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	620 min	35 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
2.5 x 350	45 - 70		
3.15 x 350	80 - 100		
4.0 x 350	90 - 130		

Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.