

Nickel Base Alloy SMAW Electrodes

GNI 122

AWS A5.11 ENiCrMo-10
JIS Z 3224 E Ni CrMo-10

Product Features:

- Basic type all positional nickel base electrode for DC+ and AC polarity.
- The weld metal deposits a NiCrMo based alloy with additions of W elements.
- Excellent resistance to pitting, cracking, stress and crevice corrosion.
- Providing better corrosion resistance than 276 and 625.

Applications:

- Used for the welding of nickel-chromium-molybdenum alloys as well as for overlay cladding on carbon, low alloy, or stainless steels.
- They are also used for dissimilar joints between Inconel and incoloy alloys, and carbon, low alloy and stainless steel.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo	W	Fe
0.02	0.20	0.6	0.003	0.002	54.8	21.54	13.90	3.36	5.5

Typical mechanical properties of all-weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
475	726	29

Size (mm) & recommended welding parameters (A)

Diameter/Length	2.6/300	3.2/350	4.0/350
Flat position	65~85	70~110	95~150

Note:

1. 300 ~ 350°C x 1hr baking prior to use.
2. Recommend short arc length and low current, electrode positive (DC+).
3. Full cleaning before welding.

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