

Nickel Base Alloy SMAW Electrodes

GNI 133

AWS A5.11 ENiCrFe-2
ISO 14172-E Ni 6133
JIS Z 3224 E Ni 6133

Product Features:

- Low hydrogen type nickel base electrode for DC+ only.
- High welding performance.
- Good bead appearance and crack resistance.
- Good heat and corrosion resistance.
- Good low temperature impact toughness.
- Easy Slag removal.

Applications:

- Welding of similar grade of nickel base alloy.
- Welding of 9% Ni steel.
- Welding overlay to carbon, stainless and Ni steels.

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

C	Si	Mn	Ni	Cr	Mo	Nb	Fe
0.027	0.40	2.31	69.1	16.6	1.11	1.93	8.43

Typical mechanical properties of all-weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact Value (-196°C) J
421	609	45	63

Size (mm) & recommended welding parameters (A)

Diameter	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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