

Nickel Base Alloy SMAW Electrodes

GNI 134

AWS A5.11 ENiCrFe-4
ISO 14172-E Ni 6093
JIS Z 3224 E Ni 6093

Product Features:

- Nickel Chromium Iron electrode formulated to permit easy operation from arc blow with AC current.
- Features good bead appearance and slag removal performance.
- The weld metal provides excellent strength and toughness at cryogenic temperatures.

Applications:

- Used for welding similar grade of nickel base alloys, 9% Ni steel for cryogenic

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

C	Si	Mn	Ni	Cr	Mo	Nb	Fe
0.056	0.42	2.21	69.1	15.60	1.60	2.10	8.56

Typical mechanical properties of all-weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact Value (-196°C) J
407	669	34	42

Size (mm) & recommended welding parameters (A) AC & DC+

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
3. Full cleaning before welding.

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