

Nickel Base Alloy SMAW Electrodes

GNI 277

AWS A5.11 ENiCrMo-5
ISO 14172-E Ni 6275
JIS Z 3224 E Ni 6275

Product Features:

- Low hydrogen type nickel base electrode for DC+ only.
- High welding performance.
- Easy slag removal.
- Mo and W contained in weld metal to get good elevated high temperature hardening tendency and strength, acid corrosion resistance.

Applications:

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

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

C	Si	Mn	Ni	Cr	Mo	W	Fe
0.06	0.30	0.44	59.2	15.9	15.50	3.45	5.2

Typical mechanical properties of all-weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
494	745	38

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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