

# Nickel Base Alloy SMAW Electrodes

## GNI 620

AWS A5.11 ENiCrMo-6  
JIS Z 3224 E Ni CrMo-6

### Product Features:

- Basic type all positional nickel base electrode for DC+ and AC polarity.
- Features good bead appearance and slag removal performance.
- The weld metal deposits a NiCr-based alloy with additions of Mo, W and Nb elements.
- Excellent impact toughness at -196°C.

### Applications:

- Used for welding 9% Ni steels for cryogenic application down to -196°C and dissimilar welds especially where carbon steels are joined to stainless steels and to Nickel-based alloys.

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

C	Si	Mn	Ni	P	S	Cr	Mo	Nb+Ta	W	Fe
0.02	0.24	2.5	67.9	0.003	0.005	16.0	5.4	1.60	1.30	4.7

Typical mechanical properties of all-weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact Value (-196°C) J
395	684	44	115

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.
3. Full cleaning before welding.

Goodweld Corporation  
No.99, Huangong Rd. Yongkang Tainan, Taiwan  
Phone: 886-6-2331003 Fax: 886-6-2333213  
All Right Reserved

  
**GOODWELD**  
[www.goodweld.com.tw](http://www.goodweld.com.tw)