NI-C1S PREMIARC™

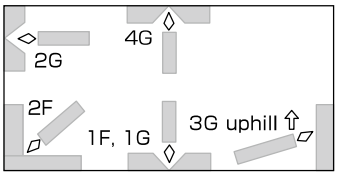
Stick electrode

Features: ▪ Suitable for 9% Ni steel

Classification: AWS A5.11 ENiMo-8

Redrying Conditions: 200~250℃x0.5~1h
Identification color: 1st Yellow, 2nd Green
Polarity: AC

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	300	2	20	30	300W, 100H, 330L
4.0	350	5	20	55	175W, 130H, 380L
5.0	350	5	20	84	175W, 130H, 380L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.02	0.10
Si	0.47	0.75
Mn	0.3	1.5
P	<0.01	0.02
S	0.001	0.015
Ni	68.7	60.0min.
Cr	1.8	0.5~3.5
Mo	18.4	17.0~20.0
Cu	0.01	0.50
Fe	7.0	10.0
W	2.9	2.0~4.0

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	70~115	65~110
4.0	100~145	85~135
5.0	130~200	-

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	473	-
TS (MPa)	750	655min.
El on 4d (%)	46	25min.
IV -196℃ (J)	92	-

Approvals

NK	KMWL92, KMWL92-YP420M-TS690M

Note: AC