NI-C70A PREMIARC™

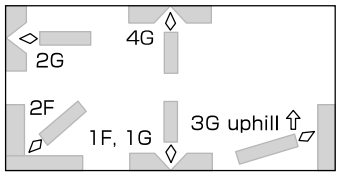
Stick electrode

Features:
- Suitable for Inconel and dissimilar-metal joints such as Inconel to low alloy steel, and stainless steel to low alloy steel

Classification: AWS A5.11 ENiCrFe-1

Redrying Conditions: 200~250℃x0.5~1h
Identification color: 1st Silver, 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	29	300W, 100H, 330L
4.0	350	5	20	51	175W, 130H, 380L
5.0	350	5	20	80	175W, 130H, 380L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.04	0.08
Si	0.20	0.75
Mn	3.0	3.5
P	0.01	0.03
S	0.003	0.015
Ni	72.0	62.0min.
Cr	14.7	13.0~17.0
Cu	0.01	0.50
Nb+Ta	1.8	1.5~4.0
Fe	7.9	11.0

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	95~145	85~135
5.0	115~170	-

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	380	-
TS (MPa)	610	552min.
El on 4d (%)	44	30min.
IV -196℃ (J)	93	-