NI-C70S PREMIARC™

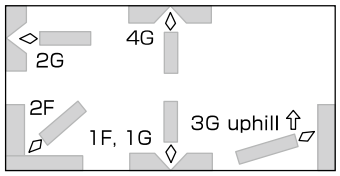
Stick electrode

Features: ▪ Suitable for 9% Ni steel

Classification: AWS A5.11 ENiCrFe-9

Redrying Conditions: 200~250℃x0.5~1h
Identification color: 1st Silver grey, 2nd Pink
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	53	175W, 130H, 380L
5.0	350	5	20	82	175W, 130H, 380L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.08	0.15
Si	0.26	0.75
Mn	2.4	1.0~4.5
P	0.01	0.02
S	<0.01	0.015
Ni	66.6	55.0min.
Cr	13.8	12.0~17.0
Mo	3.9	2.5~5.5
Cu	0.02	0.50
Nb+Ta	1.5	0.5~3.0
Fe	10.3	12.00
W	0.6	1.5

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	115~180	-

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	450	-
TS (MPa)	703	655min.
El on 4d (%)	43	25min.
IV -196℃ (J)	63	-

Approvals

ABS	MG (AWS A5.11 ENiCrFe-9)
LR	5Nim,9Nim
DNV	MG (VL9Ni), H10
BV	UP (ENiCrFe-9)
NK	KMWL92
CCS	9Ni
KR	L91

Note: AC