NI-C703D PREMIARC™

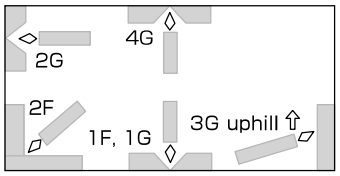
Stick electrode

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-3

Redrying Conditions: 200~250℃x0.5~1h
Identification color: 1st Silver, 2nd Blue
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	250	2	20	16	300W, 130H, 290L
3.2	300	2	20	31	300W, 100H, 330L
4.0	350	5	20	54	175W, 130H, 380L
5.0	350	5	20	85	175W, 130H, 380L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.06	0.10
Si	0.3	1.0
Mn	6.5	5.0~9.5
P	0.004	0.03
S	0.003	0.015
Ni	69.4	59.0min.
Cr	13.2	13.0~17.0
Cu	0.03	0.50
Nb+Ta	2.0	1.0~2.5
Fe	7.90	10.00
Ti	<0.1	1.0
Co	0.03	0.12

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~80	45~75
3.2	80~110	80~105
4.0	90~140	90~120
5.0	140~180	-

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	360	-
TS (MPa)	620	552min.
El on 4d (%)	45	30min.
IV -196℃ (J)	110	-