



D&H 1223 (NS)

CODIFICATION: AWS : SFA 5.11 ENiCrMo-3

CHARACTERISTICS AND APPLICATIONS:

- A non-synthetic electrode depositing homogeneous Ni-Cr-Mo alloy composition.
- A soft and smooth arc, which is easy to strike and re-strike.
- Good resistance to abrasion, oxidation, and corrosion.
- Radiographic quality weld metal of superior properties.
- Easy detachable slag.

Ideal for welding Ni-Cr-Mo alloys to themselves and to steel, and for surfacing steel with Ni-Cr-Mo weld metal. The electrodes are used in applications where the temperature ranges from cryogenic to 540°C. It also can be used for welding Ni base alloys to steel. Ideal for valves, valve seats, impellers, guide points, bushing, bearings, journals, hot working tools like hot shear blades, forging dies, trimming dies, piercing punches etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Cr	Ni	Mo	Nb + Ta	Fe
Percent	: 0.06	0.6	0.50	21	Bal.	9.0	3.5	5.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 4d)%
772	34.0

CURRENT AND PACKING DATA: DC (+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range	:	150-180	120-150	80-110	60-70
(Amps)					
Weight/Carton	:	2.5	2.5	2.5	2.5
(kgs)					

PRECAUTIONS:

1. Use short arc and stringer beads.
2. Redry the electrodes at 300-325°C for one hour.
3. Best results are obtained in flat position and wherever possible weld in flat position only.