

D&H 1280

CODIFICATION : **AWS :** SFA 5.11 ENi-1

CHARACTERISTICS AND APPLICATIONS:

D&H 1280 is a basic coated electrode depositing a pure nickel weld metal, ideally suited for welding wrought and cast of commercially pure nickel to themselves, welding nickel to carbon steels, overlays on steels to resist corrosion in caustic soda service and marine atmosphere.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	:	C	Mn	Si	Ni	Fe	Ti	Al
Percent	:	0.04	0.60	0.50	balance	0.60	2.0	0.60

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS	Elongation
(MPa)	(L=4d)%
436	25.0

CURRENT & PACKING DATA: DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5 x 350
Dia x Length					
Current Range (Amps)	:	150-180	120-150	80-110	60-70
Weight / Carton (kgs)	:	2.5	2.5	2.5	2.5

APPROVALS: BHEL

PRECAUTIONS:

1. Redry the electrode at 300-325°C for one hour.
2. Clean the weld area thoroughly free from all contamination.
3. Use short arc and minimise heat input.
4. Wherever possible weld in flat position only.