



D&H 1414 (NS)

CODIFICATION: AWS : SFA 5.11 ENiCrMo-14

CHARACTERISTICS AND APPLICATIONS:

D&H 1414 (NS) provide excellent operating characteristics for groove and fillet welding in down hand position and smaller diameter electrodes are suitable for all position welding. Weld metal gives good resistance to the corrosion, resistance to reducing, oxidizing, crevice and pitting corrosion. It is suitable to join duplex, super duplex and super austenitic stainless steels and ideally suitable for nickel alloys such as Inconel alloy C-276, 622, 625, 686, UNS N06059 and N06022. Typical applications are include chemical, process, petrochemical, oil and gas, marine industries, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Elements	C	Mn	Fe	Si	P	S	Cr	Ni	Mo	W	Cu	Ti
Percent	0.010	0.65	3.5	0.20	0.012	0.015	20.0	Bal	16.0	3.5	0.25	0.15

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L=4d) %
720	35.0

CURRENT AND PACKING DATA: DC(+)

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

PRECAUTIONS:

- 1 Re-dry the electrodes at 300-325°C for one hour.
- 2 Use short arc, stringer beads, and low currents.