Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

D&H 1423 (NS)

CODIFICATION: **AWS** : SFA 5.11 ENiCrMo-10

CHARACTERISTICS AND APPLICATIONS:

D&H 1423 (NS) is an ideal non synthetic electrode for welding Ni-Cr-Mo alloys as well as the clad side of joints in steel clad with a Ni-Cr-Mo alloy and for welding Ni-Cr-Mo alloys to steel and to other nickel base alloys. It is suitable for welding components in plants for chemical processes with highly corrosive media. Typical base materials which are welded with this product are ASTM B574, B575, B619, B622 and B626 with UNS No. N06022. Ideal for C-22 alloys.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	S	P	Cr	Ni	Mo	Fe	W	Cu	V	Co
Percent	0.015	0.80	0.17	0.008	0.02	21.0	Bal.	13.5	< 6.0	3.0	0.3	0.2	0.6

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	%Elongation (L = 4d)	CVN Impact Strength at 27°C(J)	Lateral Expansion at 27°C(mm)
740	35.0	75	0.80

CURRENT AND PACKING DATA: DC(+)

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