50 YEARS 1966 - 2016

Estd. 1966
D&H sécheron
Complete Welding Support

D&H 1200T (NS)

CODIFICATION: **AWS** : SFA 5.11 ENiCrFe-2

CHARACTERISTICS AND APPLICATIONS:

A non-synthetic electrode depositing homogeneous Ni-Cr-Fe alloy composition. Ideally suited for:

- Welding Ni-Cr-Fe alloys to themselves.
- Welding dissimilar metals such as carbon steel, stainless steel, nickel base alloys and pure nickel to themselves or to each other.
- It is also used for welding SS 201LN type materials to get good toughness together with strength.
- For overlaying Ni-Cr-Fe alloy.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	:	C	Mn	Si	Cr	Ni	Mo	Nb	Fe
Percent	:	0.04	2.5	0.4	15.0	Bal.	1.5	1.5	7.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	%El (L=4d)	CVN Impact Strength at minus 196°C(J)	Lateral Expansion at minus 196°C (mm)
644	35	45	0.42

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

APPROVALS: Adani Infra, CIB-MP, L&T Power

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.