



D&H 1227 (NS)

CODIFICATION: AWS : SFA 5.11 ENiCrMo-7

CHARACTERISTICS AND APPLICATIONS:

A non-synthetic nickel base electrode, depositing weld metal of Ni-Cr-Mo-Co-Ti-W alloys. The weld deposit resists corrosion resistance at room temperature as well as resistance to oxidation and reducing atmospheres at elevated temperatures. Electrodes are used for welding Ni-Cr-Mo alloy, for the welding of the clad side of joints in steel clad with Ni-Cr-Mo alloy, and for joining Ni-Cr-Mo alloys to steel and to other nickel base alloys. Some of the materials, which are welded with these electrodes, are ASTM B 574, B 575, B 619, B 622 and B 626 having UNS number N 06985.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element:	C	Mn	Si	S	P	Fe	Ni	Cr	Mo	Co	Ti	W
Percent:	0.012	0.90	0.12	0.020	0.024	2.5	64.3	15.0	15.0	1.50	0.20	0.40

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L=4d) %
725	31.0

CURRENT & PACKING DATA: DC(+)

Size (mm)	: 5x350	4 x 350	3.15 x 350	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

PRECAUTIONS:

1. Redry the electrode at 300-325°C for one hour before use.
2. Operate the electrodes wherever possible, weld in flat position only.
3. Maintain a short arc, use stringer bead and minimize the heat input.