



D&H 1260 (NS)

CODIFICATION : **AWS :** SFA 5.11 ENiCrMo-6

CHARACTERISTICS AND APPLICATIONS:

D&H 1260 (NS) electrode is depositing a Ni-Cr-Mo alloy ideal for welding 9% Nickel steel and other applications as well. A soft and smooth arc, which is easy to strike and re-strike. The weld metal is of radiographic quality and displays a good combination of strength and impact strength even at 196°C. Electrode of size up to 3.15mm can be used for welding all positions. It is recommended to use other sizes in horizontal and flat positions for achieving better results. It is ideally suited for welding 9% Ni steels used in LNG terminal etc. and other similar composition alloy to themselves. Typical specifications of base metal which can be welded with this electrode are ASTM A333, A334, A353, A522 & A553 etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Elements	C	Mn	Fe	Si	Cu	Ni	Cr	Nb+Ta	Mo	W
Percent	0.08	2.8	8.0	0.45	0.3	66.0	13.0	1.5	6.0	1.5

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L=4d) %	CVN Impact Strength at Minus 196°C (J)	Lateral Expansion (mm)
695	36	75	1.3

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

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.