

ROYAL CAST Mo -6 (E NiCrMo-6)

AWS: SFA 5.11, E NiCrMo-6 EN ISO 14172 A E Ni 6620

Applications

Electrodes of this classification are used for welding 9% Nickel steel base metal are ASTM A333, A334, A353, A522, and A553 etc.

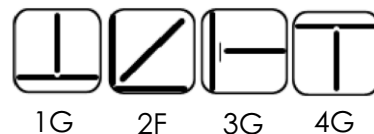
Characteristics on Usage

This type of electrode is used for welding of 9% nickel-chromium and molybdenum Alloys Steel. For surfacing steel with nickel – chromium molybdenum weld metal deposit 65%Ni, 14.5%Cr, 7%Fe, 7%Mo, 3%Mn, 1.5%W, and 1.5%Nb plus Ta electrode having diameter 3.15 for welding in all position and 4.0, 5.0 diameters for flat horizontal position with easily slag removal and good bead finish.

Packing

Vaccum packing

Welding Positions



Notes On Usage

- Chip off base metal completely at the repairing part.
- There is possibility that cracks spreads or makes holes at both ends of repairing part.
- Keep the weld metal length less than 50 mm (2 inch) to disperse welding heat- adopt back stepping stone or symmetry method by turns.
- The preheat temprature vary in accordance with te size ,king and shape of the base metal 150°C is appropriate in general.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.10 Max	2.0 – 4.0	1.00 Max	0.020 Max	0.030 Max	12.0 - 17.0	55.0 Min	5.0 - 9.0

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %	BEND TEST
620 Min	20 % Min	Satisfactory

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC/DC (+)	80 – 100
3.15 x 350	2	10		100 – 140
4.00 x 350	2	10		140 – 180
5.00 x 350	2	10		180 – 230