AK ENiCrFe-3 AWS A5.11 ENiCrFe-3

Nickel Alloy welding electrodes

Low hydrogen type of manual electrode, with nominal composition 65%Ni -15%Cr-8% Fe-7.5% Mn-2%Nb+Ta-1.5%Mo.is Ni-Cr-Fe alloy manual electrode; Has higher high temperature strength and oxidation resistance due to the higher alloy content,and can adjust a range from low temperature to 480C;Stable arc, beautiful weld bead appearance,few spatter. easy slag removal,excellent blowhole resistance,and stable deposited metal mechanical properties.

3.2mm **Lot No.： AD4090701** **Date：Aug.05.06**

AK ENiCrFe-3	EN ISO 14172	AWS A5.11	Certificate number
Welding electrodes	E Ni 6182	ENiCrFe-3	2408-0501

CHEMICAL COMPOSITION OF WIRE（%）

	C	Si	Mn	S	P	Ta	Nb	Ni	Cr	Fe	Ti	Cu
%	0.057	0.50	6.81	0.006	0.010	0.10	2.52	68.85	15.68	5.30	0.12	0.08

THE TESTRESULTS OF MECHANICAL PROPERTY OF DEPOSITED METAL

Tension Test			Impact test	
Tensile Strength（Mpa）	Yield Point （Mpa）	Elongation （%）	Temp （0C）	Impact Value(J)
610	410	32	——	——

Bend test—Face	Bend test—Side	Redrying	X Reys Test	Dictonary flux	HRC	HD
——	——	OK	——	——	——	——

2.0mm （5/64″）	2.5mm(3/32″)	3.2mm(1/8″)	4.0mm(5/32″)	5.0mm(3/16″)
——	350mm	350mm	350mm	——

NOTICE: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.