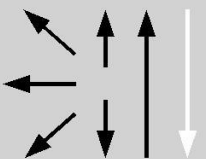


NiCrFe-3

basic coated NiCrFe stick electrode

Classifications								
EN ISO 14172		AWS A5.11			Material-No.			
E Ni 6082 (NiCr20Mn3Nb)		E NiCrFe-3 (mod.)			2.4648			
Characteristics and field of use								
<p>TOKO E NiCrFe-3 is predominantly used for joining identical or similar heat resistant Ni-base alloys, heat resistant austenites, cold tough Ni-steel, and for joining heat resistant austenitic-ferritic materials, such as 2.4817 (LC NiCr15Fe), 1.4876 (X10 NiCrTiAl 32 20), 1.4941 (X8 CrNTi 18 10). Specially also used for joinings of high C content 25/35 CrNi cast steel to 1.4859 or 1.4876 for petrochemical installations with working temperatures up to 900° C. The welding deposit is hot cracking resistant and does not tend to embrittlement.</p> <p>The welding deposit of TOKO E NiCrFe-3 is hot cracking resistant, does not tend to embrittlement scale resistant at high temperatures.</p>								
Typical analysis in %								
C	Si	Mn	Cr	Mo	Nb	Ni	Fe	
0.025	0.4	5.0	19.0	1.5	2.2	balance	3.0	
Mechanical properties of the weld metal								
Heat-treatment	Yield strength R _{P0,2}		Tensile strength R _m		Elongation A		Impact Strength Kv	
	MPa		MPa		%		J	−196 °C
As welded	420		680		40		120	80
15 h 650° C / air							120	70
Welding instruction								
<p>Hold stick electrode as vertically as possible, only very little weaving. Fill end crater carefully. Interpass temperature max. 150° C. Redry electrode for 2 – 3 h / 250 – 300° C.</p>								
Welding positions								
<div><div></div><div>Current type DC (+)</div></div>								
Approvals								
TÜV (No. 00230), KTA, ABS, GL, BV, DNV								
Recommended welding parameters								
Electrodes Ø x L [mm]	2,0 x 250		2,5 x 300		3,2 x 300		4,0 x 350	5,0 x 400
Amperage [A]	35 – 50		50 – 70		70 – 95		90 – 120	120 – 160

