

COVERE ELECTRODES FOR NCKEL ALLOY STEEL

DESCRIPTION & APPLICATIONS :

- SNF-3 is a nickel-based low hydrogen electrode designed for DC current. With excellent heat and corrosion resistance. The electrode can provide reliable from low temperature till 480°C ambient.
- Suitable for pressure vessel and chemistry storage tank. Dissimilar steels welding like Inconel and low alloys, stainless steel.

NOTE ON USAGE :

- Rebake the electrodes at 350~400°C for 60 minutes prior to use. Put daily use quantity in thermostat-container with 100~150°C during usage.
- Follow the recommended welding parameters and maintain short arc length.
- Backstep is the welding method to prevent blowholes during the arc starting.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Fe	Nb
0.050	7.5	0.4	0.001	0.02	69.50	14.00	6.8	1.43

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -196 °C J(Kgf-m)
620(63.2)	39	90(9.2)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current (Amp)	F	60-90	80-120	110-160	150-180
	V & OH	60-80	65-105	95-140	-