

## COVERE ELECTRODES FOR NCKEL ALLOY STEEL

### DESCRIPTION & APPLICATIONS :

- SNM-4 is a nickel-based low hydrogen electrode. Designed for DC current with less C for reducing carbide precipitation in grain boundary.
- Suitable for welding HASTELLOY C-276, nickel alloy and mild 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	Mo	Fe	W
0.018	0.36	0.18	0.001	0.001	59.00	15.83	15.76	5.8	3.77

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	ELONGATION RATE %
740(75.5)	40

### 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	70-120	100-150	120-180
	V & OH	55-80	65-110	80-140	-