

Nickel alloy Covered Electrodes

KNCF-3

For nickel alloy (Inconel 600, 601)

Classifications

EN ISO 14172:2004	: E Ni 6182	JIS Z 3224	: DNiCrFe-3
AWS A5.11-05	: ENiCrFe-3	KS D 7021	: DNiCrFe-3

Description

- Covering is low hydrogen type for welding of Ni-Cr-Fe alloy steel (Inconel 600, 601) or different materials, such as Inconels, Inconel and low alloy steels, stainless steels and low alloy steels.
- KNCF-3 makes safety welding with good weldability and usability.
- Excellent heat resistance, corrosion resistance and mechanical quality of all weld metal.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Fe	Ni	Cr	Ti	Nb+Ta
0.06	0.42	7.95	0.010	0.007	3.9	Rem.	16.2	0.02	1.9

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.11		min. 550	min. 30	
EN ISO 14172	min. 360	min. 550	min. 27	
Example	500	650	42	AW

* AW : As-Welded

Sizes available and recommended currents (DC+)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp. (A)	F V:OH	60-80 55-70	90-130 80-100	120-150 100-140	150-180 -

Approvals

CE