

Exaton Ni60 LFe

Ni-based CrMoNb electrode for welding of Ni-alloys of the same or similar type as e.g. Inconel 625, for welding of 5% and 9% Ni steel. The electrode is very suitable for welding of 254 SMO, i.e. UNS S31254 steel. It provides an all weld metal with an Fe content less than 1%.

Specifications

Classifications	SFA/AWS A5.11 : ENiCrMo-3 EN ISO 14172 : E Ni 6625 (NiCr22Mo9Nb)
Approvals	ABS : ENiCrMo-3

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Alloy Type	Ni-based CrMoNb
Coating Type	Basic

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	520 MPa	800 MPa	39 %
PWHT 10 hour(s) 610 °C	550 MPa	830 MPa	
ISO			
As Welded	530 MPa	800 MPa	43 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
AWS		
PWHT	20 °C	87 J
PWHT	-196 °C	74 J
As Welded	-196 °C	72 J
As Welded	20 °C	85 J
ISO		
As Welded	20 °C	90 J
As Welded	-196 °C	75 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Nb	Fe	Nb+Ta
0.03	0.2	0.4	64.0	21.7	9.0	3.4	0.5	3.5

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 300.0 mm	55-75 A	24 V	70 %	49 sec	0.83 kg/h
3.2 x 350.0 mm	65-100 A	24 V	75 %	63 sec	1.2 kg/h
4.0 x 350.0 mm	80-140 A	25 V	70 %	62 sec	1.75 kg/h