



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	550 MPa	830 MPa				
10 hour(s) 610 °C						
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 %								
С	Mn	Si	Ni	Cr	Мо	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	