

Exaton Ni60

Exaton Ni60 is a nickel-chromium-molybdenum covered electrode for welding of Ni/Cr/Mo nickel alloys, highalloy stainless steels and 5-9%Ni steels in cryogenic applications. It can be used in many variants of dissimilar joining of nickel alloys, stainless steels and low alloyed steels. Exaton Ni60 can also be used for overlay welding on low alloyed steels. The electrode combines good welding properties in all positions with very low impurity levels, high impact strength and excellent corrosion resistance to pitting in chloride containing media and stress corrosion cracking. Typical applications for Exaton Ni60 include components in the chemical and petrochemical industries often in connection with sea-water cooling where pitting corrosion and stress corrosion cracking are a risk, pressure vessels, heat exchangers etc. It is also used in sour gas service where it is approved by ISO 15156/NACE MR0175. Common base materials welded are ASTM UNS: S31254, N06625, N08825 and N08020.

Dane techniczne

Klasyfikacje	SFA/AWS A5.11 : ENiCrMo-3 EN ISO 14172 : E Ni 6625 (NiCr22Mo9Nb)
Aprobaty	VdTÜV : 04796

Zatwierdzenia s oparte na lokalizacji fabryki. Aby uzyska wiecej informacji, skontaktuj si z ESAB.

Prd spawania	DC+
Rodzaj stopu	Ni-based CrMoNb
Rodzaj otuliny	Basic

Typowe waciwoci mechaniczne

Warunki	Granica plastycznoci	Wytrzymaao na rozciąganie	Wyduenie wzgldne
ISO			
Po spawaniu	520 MPa	820 MPa	38 %

Udarno Charpy V

Warunki	Temperatura testu	Udarno KV
ISO		
Po spawaniu	-196 °C	65 J
Po spawaniu	20 °C	70 J

Typowy skad chemiczny stopiwa %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Nb
0.03	0.23	0.4	<=0.01	<=0.015	63	22	9	0.01	3.4

Typowy skad chemiczny stopiwa %

Others tot	Fe	Nb+Ta
<=0.50	<=2	3.4

Dane wydajności stopiwa

rednica	A	V	Sprawn (%)	Czas upalania elektrody	Wydajno stopiwa przy 90% I maks.
2.5 x 300.0 mm	55-75 A	23 V	55 %	40 sec	0.9 kg/h
3.2 x 350.0 mm	65-100 A	25 V	56 %	52 sec	1.4 kg/h
4.0 x 350.0 mm	80-140 A	27 V	58 %	57 sec	1.9 kg/h
5.0 x 350.0 mm	120-170 A	24 V	58 %	72 sec	2.1 kg/h