D&H 1200T (NS)

CODIFICATION:

AWS : SFA 5.11 ENiCrFe-2

EN ISO : 14172 E Ni 6133

CHARACTERISTICS AND APPLICATIONS:

A non-synthetic electrode depositing homogeneous Ni-Cr-Fe alloy composition. It is good resistance to abrasion, oxidation, and corrosion. It is suitable for welding Ni-Cr-Fe alloys to themselves, dissimilar metals such as carbon steel, 9% nickel steel, stainless steel, pure nickle to themselves or to each other, and for surfacing steel with Ni-Cr-Fe weld metal. It is ideally suitable for welding Ni alloy UNS N06600. It is also used for welding SS201LN type materials to get good toughness together with strength.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	Cr	Ni	Mo	Nb + Ta	Fe
Percent	0.04	2.5	0.4	15.0	Bal.	1.5	1.5	7.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L = 5d)%	CVN Impact Strength at minus 196°C(J)	Lateral Expansion at minus 196°C (mm)
644	35.0	45	0.42

CURRENT AND PACKING DATA: DC (+)

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	150-180	90-130	70-90	60-70
Weight/Carton (kgs)	2.5	2.5	2.5	2.5

APPROVALS: Adani Infra, CE, CIB-MP, L&T Power

PRECAUTIONS:

1. Use short arc and stringer beads.
2. Ensure the electrodes are dry. Re-dry the electrodes at 300-325°C for one hour.
3. Best results are obtained in flat position and wherever possible weld in flat position only.