55 YEARS Since 1968

Estd. 1966
D&H sécheron
Complete Welding Support

D&H 1223 (NS)

CODIFICATION:

AWS : SFA 5.11 ENiCrMo-3

EN ISO : 14172 E Ni 6625

CHARACTERISTICS AND APPLICATIONS:

A non-synthetic electrode depositing homogeneous Ni-Cr-Mo alloy composition. It is good resistance to abrasion, oxidation, and corrosion. It is suitable for welding Ni-Cr-Mo alloys to themselves and to steel, and for surfacing steel with Ni-Cr-Mo weld metal and ideally suitable for welding Ni alloy UNS N06625. The electrodes are used in applications where the temperature ranges from cryogenic to 540°C. Ideal for valves, valve seats, impellers, guide points, bushing, bearings, journals, hot working tools like hot shear blades, forging dies, trimming dies, piercing punches etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	Cr	Ni	Mo	Nb + Ta	Fe
Percent	0.06	0.6	0.50	21	Bal.	9.0	3.5	5.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L = 5d)%
772	34.0

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

APPROVAL: CE

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.