55 YEARS Since 1968

Estd. 1966
D&H sécheron
Complete Welding Support

D&H 1225 (NS)

CODIFICATION: **AWS :** SFA 5.11 ENiCrCoMo-1

CHARACTERISTICS AND APPLICATIONS:

A non-synthetic Inconel type of electrode, depositing weld metal of Ni-Cr-Co-Mo alloy. The weld metal has excellent crack resistance. Electrodes are used for welding similar type of alloys to themselves and to steel and for surfacing steels with Ni-Cr-Co-Mo weld metal. The electrodes are also used for applications where optimum strength and oxidation resistance is required above 820°C & up to 1150°C, especially when welding on base metal of Nickel-Iron-Chromium alloys. Specially recommended for welding furnace heating elements, reformer tubes etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Fe	Si	Ni	Co	Cr	Nb + Ta	Mo
Percent	0.07	1.5	4.5	0.50	48.0	12.0	24.0	0.3	9.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L = 4d) %
665	29

CURRENT & PACKING DATA: DC(+)

Size (mm) Dia x Length	:	5 x 350	4x350	3.15x350	2.5 x 350
Current Range (Amps)	:	150-180	120-150	80-110	60-70
Weight / Carton (Kgs)	:	2.5	2.5	2.5	2.5

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 300-325°C for one hour.
2. Operate the electrodes wherever possible, weld in flat position only.
3. Maintain a short arc, use stringer bead and minimize the heat input.