

LKE-NiCrFe-1



LINKWELD ALLOYS INC.

AWS A5.11 ENiCrFe-1
JIS Z3224 DNiCrFe-1J

Characteristics:

LKE-NiCrFe-1 is a low hydrogen type covered electrode. The weld metal provides excellent machining property, good heat resistance, good corrosion resistance, good toughness especially at low temperature.

Applications:

It is suitable for the welding in all position of INCONEL ,INCONEL to stainless steel ,INCONEL to low alloy steel or stainless steel to low alloy steel.

Notes on Usage:

- 1.Use small amperage as possible and keep the arc as short as possible.
- 2.Dry the electrode at 350-400°C for 30-60 minutes.

Typical chemical composition of weld metal (wt%)

| C | Mn | Si | P | S | Cr | Ni | Nb | Fe | Co |
|------|------|------|-------|-------|-------|-------|------|------|------|
| 0.06 | 3.20 | 0.24 | 0.006 | 0.007 | 14.50 | 71.10 | 2.20 | 9.23 | 0.11 |

Typical mechanical properties of weld metal

| TS N/mm ² | EL % | IV -196 °C J |
|----------------------|------|--------------|
| 620 | 42 | 89 |

Welding position:



Sizes and recommended current range (DC <+>)

| Diameter (mm) | | 2.6 | 3.2 | 4.0 | 4.8 |
|------------------------|------|-------|--------|--------|---------|
| Length (mm) | | 300 | 350 | 350 | 350 |
| Amps | F | 60-90 | 70-115 | 95-145 | 140-180 |
| | V&OH | 55-80 | 65-110 | 85-135 | - |
| Weight per pack(kg) | | 5 | 5 | 5 | 5 |
| Weight per carton (kg) | | 20 | 20 | 20 | 20 |