



LKE-NiCrFe-2

LINKWELD ALLOYS INC.

AWS A5.11 ENiCrFe-2
JIS Z3224 DNiCrFe-2

Characteristics:

LKE-NiCrFe-2 is a low hydrogen type and nickel-based covered electrode. The welding can be done in all position with good X-ray soundness and good crack resistance. The weld metal provides excellent mechanical properties which can satisfy the requirements of API and ASME for LNG tanks.

Applications:

It is suitable for welding of ASTM B163/166/167/168, Inconel600, cryogenic steels, martensitic to austenitic steels, dissimilar steels etc.

Notes on Usage:

1. Dry the electrode at 350-400°C for 30-60 minutes.
2. Use small amperage and keep the arc as short as possible.
3. Keep the interpass at 150°C.
4. Take back-step method to prevent blowhole at arc starting.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ni	Nb	Fe	Mo
0.08	1.90	0.40	0.009	0.008	14.20	68.00	1.76	9.20	2.40

Typical mechanical properties of weld metal

TS N/mm ²	EL %	IV -196 °c J
595	43	72

Welding position:



Sizes and recommended current range (DC <+>)

Diameter (mm)		2.6	3.2	4.0
Length (mm)		300	350	350
Amps	F	60-90	70-120	100-150
	V&OH	55-80	65-110	80-130
Weight per pack(kg)		5	5	5
Weight per carton (kg)		20	20	20