

## Characteristics:

LKE-NiCrFe-3 is a low hydrogen type covered electrode. The welding can be done in all position with good heat resistance, oxidizations resistance and good corrosion resistance. Good toughness can be obtained at low temperature.

## Applications:

It is suitable for welding of Inconel 600, dissimilar steels, heat-resistant steels including ASTM B163/166/167.168.

## Notes on Usage:

- 1.Be sure to clean up the contamination on the plates.
- 2.Use small amperage and keep the arc as short as possible.
- 3.Dry the electrode at 350-400°C for 30-60 minutes.
- 4.Take back-step method to prevent blowhole at arc starting.

## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ti	Nb	Fe	Co	Ni
0.035	6.5	0.35	0.01	0.008	14.50	0.01	1.20	3.5	0.01	73.5

## Typical mechanical properties of weld metal

TS N/mm <sup>2</sup>	EL %	IV -196 °C J
630	41	98

## 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	70-115	95-145
	V&OH	55-80	65-110	85-135
Weight per pack(kg)		5	5	5
Weight per carton (kg)		20	20	20