



# LKE-NiCrMo-3

LINKWELD ALLOYS INC.

AWS A5.11 ENiCrMo-3  
JIS Z3224 DNiCrMo-3

## Characteristics:

LKE-NiCrMo-3 is a nickel based low hydrogen type covered electrode which contains Mo and Nb. The excellent heat resistance and corrosion resistance can be obtained. It is suitable for chemical plant, nuclear reactor, Inconel 625, 9%Ni steel and dissimilar metals welding.

## Applications:

## Notes on Usage:

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

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

C	Mn	Si	P	S	Cr	Ni	Nb	Fe	Mo
0.07	0.78	0.32	0.002	0.004	20.80	59.60	3.52	5.40	8.90

## Typical mechanical properties of weld metal

YS N/mm <sup>2</sup>	TS N/mm <sup>2</sup>	EL %	IV -196 °c J
490	770	38	69

## Welding position:



## Sizes and recommended current range (DC <+> )

Diameter (mm)		2.6	3.2	4.0
Length (mm)		300	350	350
Amps	F	65-90	70-115	95-145
	V&OH	60-80	60-110	80-130
Weight per pack(kg)		5	5	5
Weight per carton (kg)		20	20	20