

# LKE-NiCrMo-4



LINKWELD ALLOYS INC.

AWS A5.11 ENiCrMo-4  
JIS Z3224 DNiCrMo-4

## Characteristics:

LKE-NiCrMo-4 is a nickel based low hydrogen type covered electrode which contains less C and Si to reduce carbide precipitation in grain boundary. The excellent heat resistance and corrosion resistance are obtained for chemical plant and FGD equipments.

## Applications:

It is suitable for HASTELLOY C-276 and dissimilar metal welding.

## 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	W	Fe	Mo
0.018	0.71	0.03	0.003	0.003	16.40	Bal.	3.54	5.30	16.82

## Typical mechanical properties of weld metal

TS N/mm <sup>2</sup>	EL %
735	39

## 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	60-80	60-110	80-130
Weight per pack(kg)		5	5	5
Weight per carton (kg)		20	20	20