



LKE-NiCrMo-6

LINKWELD ALLOYS INC.

AWS

A5.11 ENiCrMo-6

Characteristics:

LKE-NiCrMo-6 are AC,DC electrodes. For electrodes 3.2mm and less in size are suitable for all position and excellent weldability. Proper base metals are ASTM B333/334/353/522/553.

Applications:

For joining application of 9% Ni steel storage tank on LNG or liquefied Nitrogen, stabilized, non-stabilized Austenitic Cr Ni steel grades and cryogenic Ni steel with quenching and tempering.

Notes on Usage:

1. Dry the electrode at 350-400 °c for 60 minutes before use.
2. Keep the arc as short as possible.
3. Crater should be ground smooth or crater treatment.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	Cr	Mo	Ni	Nb	W	Fe
0.029	2.52	0.53	14.40	7.27	67.1	0.93	1.66	5.51

Typical mechanical properties of weld metal

TS N/mm ²	EL %	IV -196 °c J
685	40	74

Welding position:



Sizes and recommended current range (AC or DC <+>)

Diameter (mm)		2.6	3.2	4.0	4.8
Length (mm)		300	350	350	350
Amps	F	90-120	120-160	160-220	230-300
	V&OH	70-110	80-120	110-150	230-300
Weight per pack(kg)		5	5	5	5
Weight per carton (kg)		20	20	20	20