

## E NiCro A (Incoweld A)

**CATEGORY** SMAW Stick Electrodes

**TYPE** Nickel based high basic SMAW welding electrode.

**APPLICATIONS** Nicro A Welding Electrode is used for shielded-metal-arc welding of INCOLOY alloys 800 and 800HT, INCONEL alloys 600 and 601, and nickel steels.

**PROPERTIES** The weld metal has excellent strength and oxidation resistance at high temperatures and retains impact resistance at cryogenic temperatures. The electrode is an exceptionally versatile product for dissimilar welding. It can be used on a variety of austenitic and ferritic steels and nickel alloys.

**CLASSIFICATION**

AWS	A 5.11: E NiCrFe-2 (UNS W86133)
EN ISO	14172: E Ni 6092
DIN: W.Nr.	2.4805
DIN	1736: EL-NiCr15FeNb

**SUITABLE FOR** Nicro A electrodes are used for welding Incoloy alloys 800 and 800HT, Inconel 600 and 601 and Nickel steels. Examples are combinations of stainless steels, carbon steels, INCONEL alloys, INCOLOY alloys, MONEL alloys, and copper-nickel alloys. Because of its versatility, Nicro A Welding Electrode is especially useful for general maintenance welding of equipment exposed to strenuous service conditions.

W.Nrs:	DIN 17742 - SEW 470/595	ASTM/ACI/B366
2.4816	NiCr15Fe	Alloy 600/B168
1.4876	X10NiCrAlTi 32 20	Alloy 800/800H
1.4859	G-X10NiCrNiNb 32 20	-
2.4951	NiCr20Ti	Alloy 75
2.4952	NiCr20TiAl	Alloy 80A

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELT METAL ANALYSIS %**

Ni+Co	C	Mn	Fe	S	Si	Cu	Nb+Ta	Cr	Mo	P	Other
> 62	< 0.10	1-3.5	< 12.0	0.015	< 0.75	< 0.50	0.5-3.0	13.0-17.0	0.5-2.5	< 0.030	< 0.50

**MECHANICAL PROPERTIES**

Heat Treatment	Tensile strength		Yield strength		Elongation (%) 4d
	(PSI)	(MPA)	(PSI)	(MPA)	
AW	>80,000	>552			30

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing	
D (mm)	Length (mm)	Current (A) DC+	kg / can	kg / 6pack
2.4	229	40-65	2,27	13,62
3.2	356	65-95	2,27	13,62
4.0	356	95-125	2,27	13,62