

Exaton Ni71



Exaton Ni71 is a covered electrode with basic coating and a normal metal recovery for welding of NiCrFe alloys such as Alloy 600, 800 and 800H. 9%Ni steels as well as nickel-alloyed steels for cryogenic temperature use. It is also used for dissimilar joints such as stainless steel and NiCu alloys to carbon steel and nickel alloys. Exaton Ni71 is characterised by little spatter and very good slag removal.

Typical applications are found in constructions to be used at lower temperatures e.g. 3.5%, 5% and 9% Ni steels are used as well as austenitic Cr-Ni stainless steel, especially if the weld metal is to be thermoformed or stress relieved.

The alloy can be used in air up to 1200°C (2150°F), in sulphur dioxide atmospheres up to 800°C (1470°F) and in ammonia at the highest process temperature. This alloy is used for surfacing or joining where there are strict requirements on stress corrosion resistance and for high temperature service.

The microstructure is fully austenitic.

Clasificaciones	SFA/AWS A5.11 : ENiCrFe-3 EN ISO 14172 : E Ni 6182 (NiCr15Fe6Mn)
Aprobaciones	CE

Las aprobaciones dependen de la ubicación de la fábrica. Póngase en contacto con ESAB para obtener más información.

Corriente de soldadura	DC+
Tipo de aleación	Ni based Cr alloy
Tipo de recubrimiento	Basic

Propiedades tensoras típicas

Condición	Límite de elasticidad	Resistencia a la tracción	Alargamiento
AWS			
PWHT 16hr 610°C	400 MPa	635 MPa	50 %

Propiedades de Ensayo de impacto Charpy

Condición	Temperatura de ensayo	Valor de impacto
AWS		
PWHT 16hr 610°C	20 °C	100 J
PWHT 16hr 610°C	-196 °C	60 J

à% Análisis metal depositado (valores típicos)

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
<=0.03	5.7	0.3	<=0.010	<=0.015	67	16	0.005	0.009	0

à% Análisis metal depositado (valores típicos)

Nb	Ti	Fe	Others tot
2.2	0.08	<=10	<0.50

Datos aportación

Diámetro	Amperios	Tasa de deposición al 90 % I máx.
2.5 x 300.0 mm	50-70 A	0.0 kg/h
3.2 x 350.0 mm	65-105 A	0.0 kg/h
4.0 x 350.0 mm	75-150 A	0.0 kg/h
5.0 x 350.0 mm	120-170 A	0.0 kg/h