

## COVERE ELECTRODES FOR NCKEL ALLOY STEEL

### DESCRIPTION & APPLICATIONS :

- SNF-1 is a nickel-based low hydrogen electrode designed for DC current. With excellent heat and corrosion resistance. The electrode can provide reliable from low temperature till 980°C ambient.
- It is suitable for the welding of Inconel and dissimilar metals such as Inconel to low alloy steel or stainless steel to low alloy steel.

### NOTE ON USAGE :

- Rebake the electrodes at 350~400°C for 60 minutes prior to use. Put daily use quantity in thermostat-container with 100~150°C during usage.
- Follow the recommended welding parameters and maintain short arc length.
- Backstep is the welding method to prevent blowholes during the arc starting.

### WELDING POSITION :



### TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Fe	Nb
0.050	2.50	0.60	0.001	0.001	73.40	14.30	6.8	2.13

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	ELONGATION RATE %	IMPACT VALUES -196 °C J(Kgf-m)
622(63.5)	41	86(8.8)

### SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current (Amp)	F	60-90	80-120	110-160	150-180
	V & OH	60-80	65-105	95-140	-