

COVERE ELECTRODES FOR NCKEL ALLOY STEEL

DESCRIPTION & APPLICATIONS :

- SNM-3 is a nickel-based low hydrogen electrode designed for DC current. With excellent heat and corrosion resistance.
- It is suitable for welding nickel alloys of the same or similar type, like Inconel 625, high alloy, 9 Ni steel and mild 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	Mo	Fe	Nb
0.030	0.52	0.36	0.001	0.001	63.0	21.7	9.0	1.8	3.38

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -196 °C J(Kgf-m)
760(77.6)	39	65(6.6)

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	70-120	100-150	120-180
	V & OH	55-80	65-110	80-140	-