

COVERE ELECTRODES FOR NCKEL ALLOY STEEL

DESCRIPTION & APPLICATIONS :

- SNM-6 is a nickel-based electrode designed for AC/DC welding.
- It is suitable for LNG storage tanks, 5% or 9% Ni steel, i.e. ASTM A353 / A553.

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.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo	Nb	Fe	W
0.060	2.47	0.42	0.001	0.002	70.00	13.60	6.2	1.5	4.1	1.60

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -196 °C J(Kgf-m)
660(67.3)	39	60

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	80-130	100-170	120-180
	V & OH	55-80	65-120	80-140	-