



NEXA-222

NI-CR-FE BASIC COATED STICK ELECTRODE FOR HEAT RESISTANCE

ALLOY BASE : Ni, Cr, Mn, Fe Nb

SPECIAL FEATURES

- The electrode gives soft stable arc on low currents.
- Deposits are smooth, tough and has excellent resistance to scaling, corrosion resistance at normal as well as elevated temperature.
- Also possesses good thermal cycles and shock resistance.

APPLICATIONS

This is a versatile electrode for welding of nickel, Inconel, monel, nickel-chromium-iron alloys. Weld deposits are similar to E Ni Cr Fe-3. Stainless steel and heat resisting steels. Also for welding dissimilar metals such as carbon steels, stainless steels, nickel alloys to each other. For use on equipment and components made of pure nickel, for fabrication of corrosion resistance tanks and containers, heat exchangers, furnace components and boilers etc.

PROCEDURES

Clean the workpiece thoroughly for a crack and porosity free deposit. Adopt short arc and ensure minimum heat input using lowest possible amperage. Adopt stringer bead technique. Dry electrode for 1 hour at 300°C.

TECHNICAL DATA

Tensile Strength : 55-68 kgf / mm²
Elongation : 30-40%

CURRENT RANGE : DC(+)

SIZE mm	2.50	3.15	4.00	4.00
CURRENT (Amps)	60-80	90-110	110-140	140-160