



Selectarc B96

Basic coated high strength
Ni-base Electrode for AC

Classification

AWS A5.11 : ENiCrMo-6
UNS : W86620

ISO 14172 : E-Ni 6620 (NiCr14Mo7Fe)

Description & Applications

Basic coated electrode with approx. 160% recovery. The electrode is especially designed to weld with alternating current to avoid magnetic arc blow. Mainly used for construction and repair welding of high strength cold-tough 3; 5 and 9% Ni-steels used for transportation and storage tanks of liquid natural gas.

Base materials

UNS	Alloy	DIN	Material N°
K34718	3,5%Ni	10Ni14	1.5638
	5%Ni	12Ni19	1.5680
K81340	9%Ni	X8Ni9	1.5662

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Nb	Fe	Mo	W	Ni
<0.08	0.6	3.6	13.5	1.2	7.5	7.0	1.2	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
>420	>690	>35	+20°C	>90
			-196°C	>70

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	70-100	100-130	120-160

Redrying 1 h at 250-300°C. Joints to weld must be clean, exempt from grease, cracks . Guide electrodes with a slight declination, weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2 times core wire diameter).

ind.12



= -, + ~70V

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