

Classifications

EN ISO 14172:2004 : E Ni 6092
 AWS A5.11-05 : ENiCrFe-2

Description

- Covering is low hydrogen type for welding of Ni-Cr-Fe alloy steel (Inconel 600, 601) or different materials, such as Inconels, Inconel and low alloy steels, stainless steels and low alloy steels.
- KNCF-2 makes safety welding with good weldability and usability.
- Excellent heat resistance, corrosion resistance and mechanical quality of all weld metal.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Fe	Ni	Cr	Mo	Nb+Ta
0.02	0.37	1.69	0.011	0.005	7.94	Rem.	14.42	0.89	1.45

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.11		min. 550	min. 30	
EN ISO 14172	min. 360	min. 550	min. 27	
Example	490	620	43	AW

* AW : As-Welded

Sizes available and recommended currents (DC+)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp. (A)	F V-OH	60~80 50~70	80~120 70~100	120~150 100~140	150~180 —