

SR-133

Conformances

AWS A5.11/ ASME SFA5.11 ENiCrFe-2

JIS Z3224 DNiCrFe-2

EN ISO 14172 Ni 6092

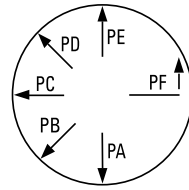
Applications

- Inconel 600, 601, Incoloy 800 and 800HT
- Dissimilar welding of stainless steels and low-alloy steels & Nickel-alloy steel(Inconel, Incoloy, Monel alloys)
- Overlay cladding on similar chemical composition steels

Features

- High impact toughness at low temperature
- Good Arc & slag stability and hot cracking resistance
- Good productivity

Welding Position



Current

DC +

Diameter / Packaging

Diameter mm (in)	Length mm(in)
	350 (14)
2.6 (3/32)	
3.2 (1/8)	✓
4.0 (5/32)	✓
5.0 (3/16)	✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Nb+Ta	Fe
0.05	0.15	3.1	0.005	0.003	15.0	71.5	1.0	0.01	1.25	7.5

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.lbs)
395 (57,000)	610 (88,000)	37.0	-196 (-321)	91 (67)

Typical Welding Parameters

Diameter	Approx. Current (Amps)		
	3.2mm (1/8) DC +	4.0mm (5/32) DC +	5.0mm (3/16) DC +
F	70~90	110~140	120~150
V-up	70~90	100~130	110~140