

# ROWELD BNI 65

SPECIALLY DESIGNED A HIGH NICKEL ALLOY  
ELECTRODE

BASIC ALLOY: NI, CR, NB, MO  
AWS/SFA-5.11: ENICRFE-2  
EN ISO 14172 E NI 6133  
(NICR16FE12NBMO)

## KEY FEATURES:

A high Nickel alloy electrode specially designed to resist crack, oxidation and corrosion. Equally provides high strength at elevated temperature. Gives smooth arc, excellent operating characteristics, easy slag detachability.

## APPLICATIONS

- Suitable to weld dissimilar metals viz carbon steel, stainless steel, Ni and Ni based alloy. Base materials: Inconel 600, Incoloy 800, Incoloy DS, Cryogenic vessels & pipe work of 3-9 % Ni steels for temperatures down to -196°C, Elevated temperatures services in furnace equipment & petrochemical plants involving temperatures up to 1000°C, Joining and Surfacing in fabrications

## RE-DRY CONDITION:

- Dry the electrode at 300°C for 1 hrs. before use

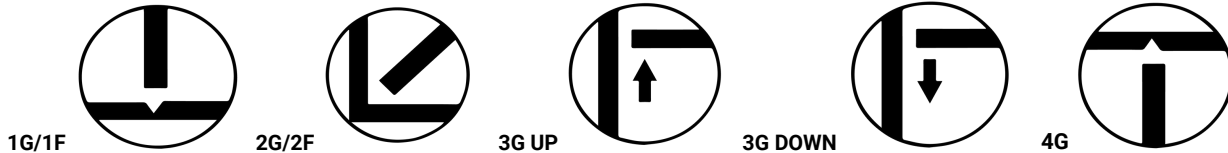
## CHEMICAL COMPOSITION:

C	Mn	Si	Ni	Mo	Cr	Fe	Nb
0.10 max.	1.00-3.50	0.75 Max	62.00 Min.	0.50-2.50	13.00-17.00	12.00 Max.	0.50-3.00

## MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @
450 Min	550 Min.	30 Min.	- 196C : 50 J Min.

## WELDING POSITION



## DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+ / AC) Amps	Kg/pkt.	Kg/Case
2.50 / 2.40	3 / 32"	60-80	2	10
3.15 / 3.20	1 / 8"	90-120	2	10
4.00	5 / 32"	110-160	2	10
5.00	3 / 16"	150-180	2	10