



Selectarc B94

Basic coated NiCrFe- Electrode
For alternative current

Classification

AWS A5.11 : ENiCrFe-2
UNS : W86133

ISO 14172 : E-Ni 6133 (NiCr16Fe12NbMo)

Description & Applications

Basic coated electrode with 150% recovery, for welding Nickel-Chromium-Iron alloys to themselves and to lower alloyed steels as well as for welding cryogenic 5 and 9% Ni-steels and high temperature steels, for CrMo-creep resistant steels to stainless steels, for repair on HK and HP reformer grades. The electrode is especially designed to weld with alternating current.

Base materials

UNS	Alloy	DIN	Material N°
	5%Ni	12Ni19	1.5680
K81340	9%Ni	X8Ni9	1.5662
N06600	600	NiCr15Fe	2.4816
N08800	800	X10NiCrAlTi3220	1.4876
N08810	800H	X5NiCrAlTi3120	1.4958
J94204	HK40	GX40CrNiSi25 20	1.4848
J95705	HP30	GX40NiCrNb35 25	1.4852

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Nb	Fe	Mo	Ni
0.06	0.5	2.8	16.0	1.7	7.0	1.8	base

All Weld Metal Mechanical Properties

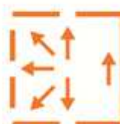
R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
>380	>620	>30	+20°C >80 -196°C >60

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	70-90	90-120	120-140

Redrying 1 h at 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. 2-3 times core wire diameter). For repair welding a preheating, depending on the carbon equivalent of the base material, in the range of 100-250°C, is recommended.

ind.12



= - , + ~ 70V

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