



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

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.