



# Selectarc Ni690

*Nickel base Electrode  
Highly corrosion resistant*

## Classification

AWS A5.11 : ENiCrFe-7      ISO 14172 : E-Ni 6152 (NiCr30Fe9Nb)

## Description & Applications

High Chromium content Nickel base electrode with basic type coating, used for repair and fabrication welding of alloy 690 and 600. Also applied as overlays on stainless steels and low-alloy steels. The weld deposit in 690 alloy is resistant to corrosion in aqueous and oxidising media. Stable arc with low spatters, easy slag removal and regular weld beads.

**Main applications:** Nuclear power plants, chemical industries...

### Base materials

UNS	Alloy	EN	Material N°
N06690	690	NiCr29Fe	2.4642
N06600	600	NiCr15Fe	2.4816

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Fe	Nb	P	S	Al	Ti	Mo	Cu	Ni
0.03	0.4	3.5	29	8.5	1.8	<0.010	<0.005	<0.1	<0.1	<0.1	<0.1	Rem.

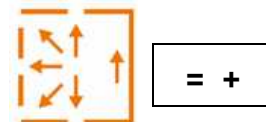
## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
420	650	40	+20°C 100

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x300	3,2x350	4,0x350	5,0x450
Current	( A )	50-70	70-100	90-120	130-160

Redrying 1h at 250-300°C. Joints to weld must be clean, exempt from grease or 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). Welding with slight or without preheating and an interpass temperature <150°C.



FT En-469-230213

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