

GOLD 510-E NICKEL ALLOY FOR SPECIAL APPLICATION

Description and Applications:

High recovery (170%) nickel base maintenance electrode.

The highly corrosion and heat resistant deposit combined with excellent mechanical properties makes this electrode a trouble shouter for many problems.

Welding of dissimilar joints, difficult to weld steels (high carbon equivalent), cushion layer, special stainless steels, heat resistant overlays, hot forging dies, shear blades, valves, pumps, shafts etc.

Used in Power stations, steel works, chemical industries, forging.

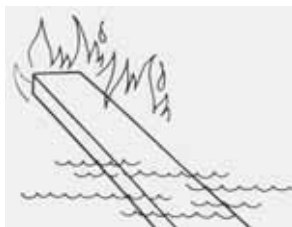
Suitable for welding 9% Ni steels, Alloy (Inconel) 625,825,904 L

Suitable for service temp.from-250°C to above 1000°C

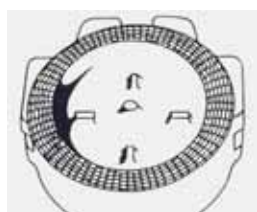
Weldmetal composition:Ni base,Cr,Nb,Mo,Fe,Mn



Repair of kiln tyre/ bearings



For high temp, application



Rebuilding gate valves



Protect hot forging tools dies



Mechanical properties

Up to :

R_m (MPa)	R_{p0.2} (MPa)	A5 (%)
790	470	35

Hardness ~ 240 HB, 450HB after work hardening

Packaging

Data

Sizes	2.5x350	3.2x350	4.0x350
Kgs/Package	4,5	4,5	4,5
Packets/carton	4	4	4
Kgs/carton	18	18	18

Welding instructions	Current (A)	85	110	140
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Welding positions



= + ~ 70V