

Shielded Metal Arc Welding

NB-3N FAMILIARC

Extra low hydrogen type electrode for all-position welding of 3.5% Ni steel for ethylene plant

Classification: ASME / AWS A5.5 E7016-G

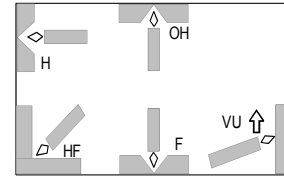
Features : •Suitable for butt and fillet welding

•The weld metal contains about 3.5% Ni

•Better impact values at temperatures down to -100°C

Redrying Conditions: 350~400°Cx1h

Welding Positions:



Typical chemical composition of weld metal (%) (AC)

	C	Si	Mn	P	S	Ni	Mo
Example	0.03	0.33	0.94	0.010	0.009	3.20	0.27

Typical mechanical properties of weld metal (AC)

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°Cxh)
Example	460	550	32	-100°C: 100 -85°C: 120	620x1

Recommended welding parameters

	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	55~85A	90~130A	130~180A	180~240A
VU, OH	50~80A	80~120A	100~170A	-

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

Packages

Dia. (mm)	Length (mm)	Weight per pack(kg)	Weight per carton (kg)	Weight per piece (g)
2.6	300	2	20	17
3.2	350	5	20	31
4.0	400	5	20	55
5.0	450	5	20	97