

NI9

☆AWS A5.11 ENiCrMo-6

For 9%Ni Steel

APPLICATIONS

Welding of 9%Ni steel for cryogenic storage tanks for LNG, Liquified nitrogen, etc.

CHARACTERISTICS

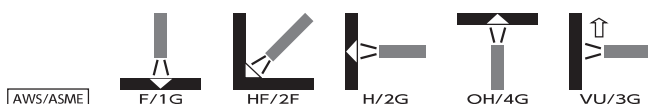
These are used for LNG Tanks, available in the all positions, have excellent welding efficiency in addition to high strength and toughness.

NI9 provides a smooth bead appearance, minimal spattering and slag is easily removable.

GUIDELINES FOR USAGE

1. Electrodes should be redried at 350°C for 60 minutes before use.
2. Arc length should be kept as short as possible during welding.
3. Crater treatment or grinding off of crater is required.
4. It should be mentioned that porosity may occur in overhead position welding.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	Mn	P	S	Cu	Fe	Ni	Cr	Nb	Mo
0.07	0.32	3.06	0.003	0.008	0.04	6.9	65.4	14.2	1.65	6.26

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength, MPa	Tensile Strength, MPa	Elongation, %	Charpy 2V-notch at -196°C, J
450	720	51	84

■ SIZES & RECOMMENDED CURRENT RANGE<AC or DC(+)>

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	350	350	350
Current A	F	70~130	120~160	140~180	190~230
	V-up, OH	70~110	110~130	110~140	—

Identification color: End-white, secondary-green