



ARCWEL 280- SMAW

For high stress & high temperature & special application

- ◆ **Inconel 600 * type nickel base maintenance electrode**
- ◆ **Welding of dissimilar joints, difficult to weld steels , cushion layer before hard facing.**
- ◆ **Weld unidentified stainless steels, heat resistant overlays, heat treating equipment , casting molds, ingot tongs etc.**
- ◆ **Used in Power station (gate valves), steel works, (steel mill roll ends, guides, tongs) chemical industries, forging etc.**
- ◆ **Repairing cracked Kiln (Kiln tire) and grinding rollers in cement works.**
- ◆ **Suitable for welding 5 % Ni steels, Alloy 600 (UNS No. 06600) Alloy 800**
- ◆ **Suitable for service temp.from-196 °C to above 1000°C**
- ◆ **E Ni Cr Fe 3 type deposit / 140 % high metal deposition coating**

* Note : Inconel are reg. trademarks of Inco Alloys

Mechanical Properties (Typical)

| Tensile Strength [MPa] | Yield Strength [MPa] | Elong. A [%] | Hardness HB |
|---------------------------|-------------------------|-----------------|----------------|
| 620-660 | 410-440 | 40 | 180-220 |



Weld Metal Composition (%) typical

| C | Cr | Mn | Fe | Nb | Si | T | Bal |
|-----------|-------|-----|-----|-----|---------|-----------|-----|
| 0,03-0,05 | 15-17 | 1-2 | 6-8 | 1-2 | 0,4-0,6 | 0,02-0,04 | Ni |

Kiln tire repair weld

Sizes /Packages

| Ø [mm] | length [mm] | current range [A] | pack [kgs.] | weight / ctn. [kgs.] |
|--------|----------------|-------------------------|----------------|----------------------------|
| 3,2 | 350 | 100 - 120 | 5 | 20 |
| 4,0 | 350 | 120- 150 | 5 | 20 |

Note: This welding alloy is also available as MIG ,(GMAW) or TIG (GTAW) Wire. Please send your request



= + ~ 70V

Disclaimer-Warranty : The information and data presented herein are typical or average values. Application suggested are made solely for the purpose of illustration to enable the reader to make his own valuation and are not intended as warranties.

Arcwel reserves the right to alter specification without further notice. **Health & Safety :** Observe safety regulations (fumes) MSDS available on request www.arcwel.com E-mail : info@arcwel.at



ARCWEL 290- SMAW

For corrosion, friction & heat resistance welds .
Ni Cr Mo 3 , Inconel 625 * alloy

- ◆ **Nickel-base maintenance electrode with high corrosion resistance**
- ◆ **Welding of dissimilar joints, difficult to weld steels** , cushion layer before hard facing.
- ◆ Weld unidentified stainless steels, heat resistant overlays, **hot forging dies**, shear blades, **valves**. pumps, shafts, turbine blades, heat exchangers etc.
- ◆ Used in Power station (gate valves), steel works, (steel mill roll ends, guides, tongs) chemical industries, forging etc.
- ◆ **Repairing boilers, & pipes in chemical & petrochemical industries**
- ◆ Suitable for welding 9% Ni steels, Alloy 300, (UNS No. 8330) (Inconel) 625, 825, 904 L. Material No. 1.5662.2.4856, 2.4858, 1.4539
- ◆ **Suitable for service temp. from -250°C to above 1000°C ***

Mechanical Properties (Typical)

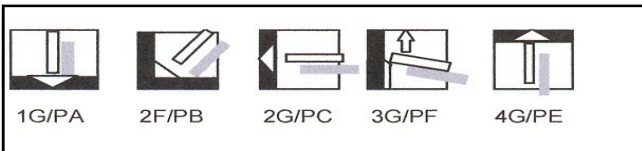
| Tensile Strength [MPa] | Yield Strength [MPa] | Elong. A [%] | Hardness HB |
|---------------------------|-------------------------|-----------------|----------------|
| 780-800 | 460-480 | 35 | 230-250 |

Weld Metal Composition (%) typical

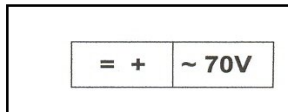
| C | Cr | Mo | Nb | Fe | Mn | Ni |
|-----------|--------------|------|-----|-----|---------|-----|
| 0.02-0.04 | 22-24 | 8-10 | 3-4 | 2-4 | 0.4-0.6 | Bal |

Sizes / Packages

| Ø [mm] | length [mm] | current range [A] | pack [kgs.] | weight / ctn. [kgs.] |
|--------|----------------|-------------------------|----------------|----------------------------|
| 3,2 | 350 | 70 - 120 | 5 | 20 |
| 4,0 | 350 | 120- 160 | 5 | 20 |



* Note : Inconel are reg. trademarks of Inco Alloys



Also available as MIG ,(GMAW)
 FCAW , TIG (GTAW) &
 ARCSpray (AS) WIRE

Disclaimer: The information and data presented herein are typical or average values. Application suggested are made solely for the purpose of illustration to enable the reader to make his own valuation and are not intended as warranties.

Arcwel reserves the right to alter specification without further notice. **Health & Safety :**
 Observe safety regulations (fumes) MSDS available on request www.arcwel.com E-mail : info@arcwel.at