

# KW-A690

AWS ENiCrFe-7

FOR NICKEL ALLOY

## Typical applications

Welding of Ni-Cr-Fe alloy steel (Inconel690).

Welding of different materials, such as inconels, inconel and low alloy steels, stainless steels and low alloy steels.

## Coating

Lime titania type.

## Characteristics on Usage

- ① Easy slag removal and stable arc.
- ② Excellent heat-resistance, corrosion resistance and mechanical quality of all-weld-metal.
- ③ Redry the electrode about 1hour at 300~350°C when the welding electrode is humid

## Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Fe	Ni	Cr	Nb+Ta
0.05	0.52	1.45	10.1	Rem.	29.5	1.2

## Typical mechanical properties of all-weld-metal

Y · P	EI
N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	(%)
670 {68}	44

## Sizes available and recommended currents (AC or DC ⊕, ⊖)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp.	F	60~80	90~130	120~150	150~180
	V&OH	55~70	80~100	100~140	—

## Welding positions



Approved by