

Ni-Cr-Fe Welding Electrode

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INCONEL® Welding Electrode 152

INCONEL Welding Electrode 152 is used for shielded-metal-arc welding of INCONEL alloy 690. It has a higher chromium content which improves resistance to stress-corrosion cracking in the nuclear, pure water environment. It was designed to produce high quality welds in all positions. This electrode also produces corrosion-resistant overlays on most low-alloy and stainless steels. Other uses include applications requiring INCONEL alloy 690 "glass melters" used for the disposal of nuclear waste. It is also useful for dissimilar joints involving INCONEL and INCOLOY alloys, and stainless, low-alloy and carbon steels.

The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive.

Specifications

AWS A5.11 ENiCrFe-7 (UNS W86152)

ASME II C SFA-5.11, ENiCrFe-7 (UNS W86152)

ASME IX, F-No.43

*(EN) ISO 14172 - ENi6152 (NiCr30Fe9Nb)

*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition

Ni+Co	Remainder	Cu.....	0.50 max.
C.....	0.05 max.	Cr.....	28.0-31.5
Mn.....	5.0 max.	Ti.....	0.50 max.
Fe	7.0-12.0	Al	0.50 max.
S	0.015 max.	P	0.03 max.
Si	0.75 max.	Nb+Ta	1.0-2.5
Mo	0.50 max.	Others	0.50 max.

Minimum Mechanical Properties

Tensile Strength, psi	80,000
MPa	552
Elongation, (4d) %	30

Available Product Forms – Supplied in 10lbs (4.54kg) hermetically sealed containers

Diameter	mm in	2.4 3/32	3.2 1/8	4.0 5/32	4.8 3/16
Length	mm in	229 9	356 14	356 14	356 14
Current (DC+)	A	45-65	75-100	95-130	125-165

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