



S. R. Industries

STAR ARC ENiCrFe-2

Alloy A (ENiCrFe-2) electrodes are used for welding of nickel-chromium-iron alloys to themselves as well as for dissimilar welding between various nickel alloys and carbon or stainless steels. There is a large range of applications from cryogenic temperatures up to 1500°F. These electrodes can also be used for overlay cladding where similar alloy is needed.

AWS Specification : A5.11/A5.11M:2010

AWS Classification			ENiCrFe-2			Welding Current			DCEP			
Typical Wire Chemistry												
C	Mn	Fe	P	S	Si	Cu	Nib	Nb (Cb) plus Ta	Mo	Co	Cr	other
0.10	1.0-3.5	12.0	0.03	0.02	0.75	0.50	62.0 min	0.5-3.0	0.5- 2.5	d	13.0- 17.0	0.50
Typical Mechanical Properties (As Welded)						Available Diameters and Operating Range in Amps						
Yield Strength, ksi				72		3/32"				65 -75		
Tensile Strength, ksi				80		1/8"				80 - 90		
Elongation%, min				30		5/32"				100 - 120		
Welding Positions				F,V,OH,H		3/16"				110 - 130		

b - includes incidental cobalt

d - is 0.12 maximum when specified by purchaser

Address : C-617, DSIDC, Narela, Delhi-110040 India

Tel : 011 47506585 **Mobile :** + 91 9911166585

E.Mail : srindus@yahoo.com

Website : www.stararc.in