

NICKEL BASED ALLOY

GLST-N654 ELECTRODE

Classification: AWS A5.11M ENiCrMo-4

EN E Ni 6276

Characteristics and Application:

GLST-N654is a Nickel base electrode for DC and the welding can be done in flat positions. The nominal composition of the weld is including 57%Ni , 15.5%Cr, 5.5Fe, 4%W, low carbon, and provides excellent mechanical property, good heat resistance, good porosity resistance and good corrosion resistance.

Excellent performance in good bead appearance, less spatter, easy slag removal and stable arc are all obtainable.

It is suitable for the welding of NiCrMo-alloy steel such as Inconel C-276, ASTM B574, B575, B619, B622, B626 and dissimilar metals welding.s

Welding Position :



Chemical Composition of Deposited Metal :

Element wt%	C	Mn	Si	Cr	Ni	Fe	P	S	W	Mo
AWS	0.02	1.0	0.2	14.5-16.5	≥50	4.0-7.0	0.02	0.015	3.0-4.5	15.0-17.0
Type Value	0.013	0.71	0.15	16.52	Bal.	5.51	0.013	0.011	3.34	16.51

Mechanical Property of Deposited Metal:

	Yield Stress MPa	Tensile Strength MPa	Elongation %	Charpy V-notch J/°C
AWS	-	690	25	-
Type Value	-	730	40	-

Notes on Usage:

- 1 Rebake the electrodes at 350-400°C for one hour before use.
- 2 Clean up the contaminations on the base metal and welding seam.
- 3 Reduce heat input as possible, and while welding with weave method, moving range should be controlled within 2.5 times of the wire’s diameter.
- 4 Notice the travel speed to prevent from slag inclusion.
- 5 Keep the inter-pass temperature under 100°C.
- 6 Filling the crater after welding to avoid from crater cracks. Grinding with the Grinder if ther crack exists and then continue welding.

Sizes and Recommended Parameters:

Diameter and Size/mm		2.6×350	3.2×350	4.0×350
Current/Amp	F	60-90	70-115	90-145