

NICKEL BASED ALLOY

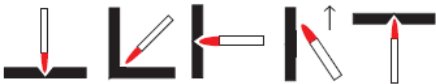
GLST-N656 ELECTRODE

Classification: AWS A5.11M ENiCrMo-6
EN E Ni 6620

Characteristics and Application:

GLST-N656 is a Nickel base electrode for DC and the welding can be done in all positions with diameter under 3.2mm. The nominal composition of the weld is including 65%Ni , 14.5%Cr, 7%Mo, 7Fe, 3%Mn,1.5%W, 1.5%Nb+Ta, and provides good appearance, little spatter, easy slag removal, excellent porosity resistance, stable mechanical property of deposited metal. It is suitable for 9%Ni steel, such as ASTM A333, A334,A522,A553.

Welding Position :



Chemical Composition of Deposited Metal :

Element wt%	C	Mn	Si	Cr	Ni	Fe	P	S	W	Mo
AWS	0.10	2.0-4.0	1.0	12.0-17.0	≥55	10	0.02	0.015	1.0-2.0	5.0-9.0
Type Value	0.029	2.4	0.50	14.51	66.8	5.52	0.013	0.009	1.71	16.51

Mechanical Property of Deposited Metal:

	Yield Stress MPa	Tensile Strength MPa	Elongation %	Charpy V-notch J/°C
AWS	-	620	20	-
Type Value	-	700	42	-

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	80-130	120-160	160-220
	V, OH	70-110	80-120	-