

HASTELLOY® B-3® Coated Electrodes

Product Description:

HASTELLOY® B-3® coated electrodes are used for the shielded metal arc welding of B-3® alloy materials. The weld metal has excellent resistance to hydrochloric acids at all temperatures and also withstands hydrogen chloride, sulfuric, acetic and hydrofluoric acids. The alloy has improved thermal stability and resistance to stress corrosion cracking over alloy B-2. The electrode can be used for the overlay and cladding of carbon and stainless steels with no butter layer needed. The coating is designed for great operability, especially in out-of-position welding.

Specifications:

AWS A 5.11 ENiMo-10 ASME IX F-43
ASME SFA 5.11 ENiMo-10 UNS W860675
Kennblatt 7617.02*
*Specify at time of order

Composition:

Nickel:	Balance	Copper:	0.50 max.
Molybdenum:	27.0-32.0	Other:	0.50 max.
Iron:	1.0-3.0	Silicon:	0.20 max.
Chromium:	1.0-3.0	Carbon:	0.02 max.
Cobalt:	3.0 max.	Sulfur:	0.03 max.
Tungsten:	3.0 max.	Phosphorus:	0.04 max.
Manganese:	2.0 max.		

Minimal Mechanical Properties:

Tensile (psi)	100,000
Mpa	690
Elongation (%)	25

Available Product Forms and Sizes:

Diameter in	0.093	0.125	0.156	0.187
Diameter mm	2.40	3.20	4.00	4.70
Length in	10	14	14	14
Length mm	254	355.6	355.6	355.6
Package Weight lbs.	5	10	10	10
Current (A) DCEP	40-70	70-100	80-140	120-150

Packaged in Hermetically Sealed Containers