Inweld NA-A

AWS A5.11 ENiCrFe-2

Chemical Composition of Inweld NA-A

C	Mn	Fe	P	S	Si	Cu	Ni	Cr	Nb (CB) & Ta	Other
0.10	1.00-3.50	12.0	0.03	0.02	0.75	0.50	62.0 min	13.0-7.00	0.50-0.30	0.50

Single values are maximum unless otherwise specified.

Description and Applications

Inweld Nickel A Stick Electrodes are used for welding of nickel-chromium-iron alloys , 9 percent nickel steel and a variety of dissimilar metal joints (involving carbon steel, stainless steel, nickel and nickel base alloys). The base metals can be wrought or cast (welding grade), or both. Typical specifications for the nickel-chromium-iron base metal are ASTM B163, B166, B167 and B168, all of which have UNS number N06600. Electrodes through the 1/8” (3.2mm) size can be used is all positions. Electrodes larger than that are used only in the horizontal and flat positions. Inweld Nickel A electrodes can also be used for overlay cladding where similar alloy is needed. Nickel A also has a wide range of applications ranging from cryogenic temperatures up to 1500°F.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	80,000 psi
Yield Strength:	65,000 psi
Elongation:	30%

Recommended Parameters

SMAW

Wire Diameter	Voltage	Amperage
3/32”		65-75
1/8”		90-105
5/32”		120-135
3/16”		135-155