

SAFINOX B NC 75 15 M

MMA Electrodes

Nickel and Copper alloys



SAFINOX B NC 75 15 M is a basic coated MMA electrode for the welding of heat and corrosion resistant nickel alloys. The weld metal retains ISO-V toughness down to -196°C and is creep-resistant < 800°C. Due to the high toughness properties and resistance to cracking, applications include the joining of difficult-to-weld steels and maintenance welding of critical components. Even at higher temperatures, there is only limited carbon diffusion in the weld metal, thus avoiding the formation of crack-prone carbides at the weld interface of dissimilar joints. The coefficient of thermal expansion is between austenitic and ferritic steels, therefore applications include the joining of ferritic to austenitic steels, dissimilar welding, at operating temperatures or postweld heat treatment > 300°C.

Classification	
EN ISO	14172: E Ni 6092
AWS	A5.11: E NiCrFe-2

Approvals		
ABS	BV	DNV
ENiCrFe2	UP	H10

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe
All weld metal	≤ 0.05	2	0.2	≤ 0.020	≤ 0.015	16	Rem	1	1.8	8.5

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation	Impact Energy ISO - V (J)	
				+20 °C	-196 °C
As Welded	≥ 360	≥ 550	≥ 35	≥ 80	≥ 60

Materials

UNS N06600; UNS N08800; UNS N08810

2.4816 (NiCr15Fe); 1.4876 (X10NiCrAlTi32-20); 1.4958 (X5NiCrAlTi31-20)

Cladding or buffer layer on steels.

Storage

Keep dry and avoid condensation.

Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

DC+

