

SUPRANEL NiCrFe7

MMA Electrodes Nickel and Copper alloys

Supranel NiCrFe7 is used for the all-positional welding of nickel alloy steels type Inconel 690. Good mechanical properties. Efficiency 100%

Classification

AWS	A5.11: E NiCrFe-7
EN ISO	14172: E Ni 6152

Approvals

Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.02	3	0.40	≤ 0.005	≤ 0.005	29	Rem	-	2	10	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -196°C	Hardness
As Welded	≥ 360	≥ 550	≥ 30	≥ 60	-

Materials

ASTM B166 - B167 - B168; UNS N06690

Storage and redrying

Keep dry and avoid condensation.
Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

DC+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
4,0	350	100-130	50,8	31,0