



ISO 9001:2015 REGISTERED  
Certificate No.: 50040 & 50415

## ENiCrFe-2 DATA SHEET

### Pinnacle Alloys ENiCrFe-2 (A)

AWS CLASS ENiCrFe-2

#### CODE AND SPECIFICATION DATA:

AWS A5.11 ASME SFA 5.11; UNS W86133

#### DESCRIPTION:

Pinnacle Alloys ENiCrFe-2 has a nominal composition (wt.-%) of 70 Ni, 15 Cr, 8 Fe, 2 Mn, 2 Nb + Ta, 1.5 Mo. Electrodes of this classification are used for welding nickel-chromium-iron alloys, 9% 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. The electrodes may be used for applications at temperatures ranging from cryogenic to around 1800°F. However, for temperatures above 1500°F, weld metal produced by ENiCrFe-2 does not exhibit optimum oxidation resistance and strength. Typical specifications for the nickel-chromium-iron base metal are ASTM B 163, B 166, B 167, and B 168, all of which have a UNS Number of N06600. Pinnacle Alloys ENiCrFe-2 provides excellent results over a wide range of general fabrication welding requirements, especially those in harsh service environments.

**TYPE OF CURRENT:** Direct Current Electrode Positive (DCEP)

**DIAMETERS:** 3/32", 1/8", 5/32", 3/16"

**WELDING POSITIONS:** All positions

5/32" & 3/16" recommended for use in flat & horizontal positions only



[www.pinnaclealloys.com](http://www.pinnaclealloys.com)

9384 Wallisville Road • Houston, Texas 77013 • 1-800-856-9353 • (713) 688-9353 • Fax (713) 688-6985  
2602 S. 50th Avenue • Phoenix, Arizona 85043 • 1-866-442-9353 • (602) 442-9353 • Fax (602) 442-9354



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### TYPICAL DEPOSIT COMPOSITION:

	AWS Spec	Weld Metal Analysis (%)
Carbon (C)	0.10	0.022
Chromium (Cr)	13.0-17.0	15.2
Cobalt (Co)	0.12*	0.034
Copper (Cu)	0.50	<0.001
Iron (Fe)	12.0	6.70
Manganese (Mn)	1.0-3.5	1.80
Molybdenum (Mo)	8.0-10.0	0.8
Nickel (Ni)	62.0 min	73.9
Phosphorus (P)	0.03	0.001
Silicon (Si)	0.75	0.24
Sulfur (S)	0.02	0.008
Niobium (Nb) + Tantalum (Ta)	0.5-2.5*	1.10

NOTE: Single values are maximums.

\*Additional customer requirements may apply.

### TYPICAL MECHANICAL PROPERTIES:

	AWS Spec (min)	As Welded
Ultimate Tensile Strength	80,000 psi (550 MPa)	85,000 psi (590 MPa)
Percent Elongation in 2"	30%	40%

### TYPICAL WELDING PARAMETERS:

Diameter	Type of Current	Amperage Range		Voltage Range
		Flat	Out of Position	
3/32"	DCEP	70-90	65-80	20-23
1/8"	DCEP	80-110	75-95	21-24
5/32"	DCEP	120-160	Not recommended	22-25
3/16"	DCEP	170-190	Not recommended	23-26

**NOTE: Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.**

**NOTICE:** The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

**CAUTION:** Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126; OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Pinnacle Alloys SDS sheets may be obtained on the website below.

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