

E Alloy B3

CATEGORY SMAW Stick Electrodes

PROPERTIES E Alloy B3 is a nickel-base alloy with excellent resistance to hydrochloric acid at all concentrations and temperatures. It also withstands hydrogen chloride, sulfuric, acetic, hydrofluoric and phosphoric acids. The alloy has improved thermal stability, fabricability and stress corrosion cracking resistance.

CLASSIFICATION

AWS	A 5.11: E NiMo-10
EN ISO	14172:
DIN: W.Nr.	2.4600
DIN	1736:

SUITABLE FOR Hastelloy B2, Hastelloy B3, dissimilar welding Hastelloy to nickel- or iron-based corrosion alloys, for weld overlay cladding

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Fe	P	S	Si	Cu	Co	Cr	Mo	W	Ni	Others
<0.02	<2.0	1.0-3.0	<0.04	<0.03	<0.2	<0.5	<3.0	1.3-3.0	27.0-32.0	<3.0	Bal.	<0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-60°C	
	475	772	49	118			

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / pack	kg / 1000
3.2	355	80-100		4.5	
4.0	355	125-150		4.5	