



PHILARK PH NI 2

Coated Electrode for High Alloyed Special Steels Difficult to Weld



General Description

PHILARK PH NI 2 has a very crack proof weld metal. It is suitable for the joining and welding of special steels used at both sub-zero and elevated temperatures, also recommended for 5-9 % nickel steels and nickel alloys such as Inconel 600, Incoloy 800, Nimonic 75, NiCr 80/20, NiCr 60/15, NiCr15Fe and dissimilar ferrous metal combinations, including stainless steel to steel.

PH NI 2 provides the ultimate fatigue resistance for highly stressed constructions using thick sections. The weld metal has a good impact strength down to -196°C and a good tensile strength up to 1000°C. Also the corrosion and oxidation resistance are good.

Crack resistance	██████████
Bonding	██████████
Machinability	██████████

Mechanical Properties of Weld Metal

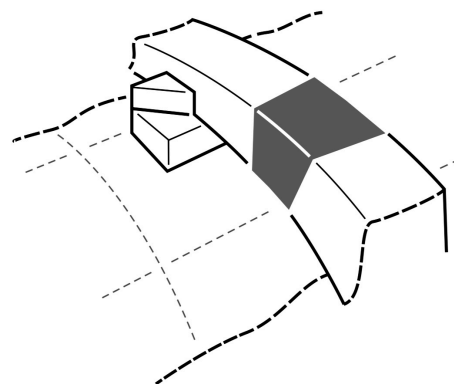
Tensile Strength : 66 - 71 kg/mm²

Elongation (L=5d) : 40 - 44 %

Hardness : 160 - 200 HB

Typical Applications

- Joining or repairing of heavily constrained massive sections - Bearing rings of rotary kilns
- Walls of ball mills
- Ball mill driving gears, journals and collars
- Blast furnaces
- Flame hardening equipments
- Heat treating trays
- Pipe flanges
- Machine parts subject to thermal cycling and sub-zero temperatures such as cryogenic equipments
- Joining dissimilar combinations of steels



Welding Parameters

Current Type and Polarity : AC/DC(+)

Bearing rings of Rotary Kilns

Diameter [mm]	2.50	3.15	4.0
Length [mm]	350	350	350
Current [A]	80-90	100-110	120-140

PHILARK ALLOYS

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