



PHILARK PH NI 44

Coated Electrode for High Alloyed Special Steels Difficult to Weld



General Description

PHILARK PH NI 44 is a basic coated electrode with Ni-Cr-Fe type nickel base deposit. Used for repairing and joining of nickel alloys, 5 - 9% Nickel steels, cryogenic stainless steels down to -196°C, Incoloy 800 and other high temperature steels. Provides a weld metal which has a operating temperatures from -196°C to 800°C. Used for joining dissimilar materials as stainless steels/low alloyed steels, stainless steels/Nickel alloys, buffering of difficult to weld steels. Weld metal deposit is insensitive to cracks, has very good resistance to acids, salts and alkaline solutions, molten salt (e.g. cyanide) in oxidizing and carburization atmospheres (avoid a sulphurous atmosphere).

Crack resistance	■	■	■	■	■
Bonding	■	■	■	■	■
Machinability	■	■	■	■	■

Mechanical Properties of Weld Metal

Tensile Strength : 66 - 68 kg/mm²

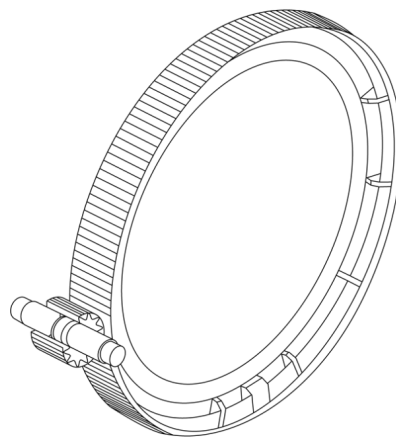
Elongation (L=5d) : 40-42 %

Hardness: 180 BHN

Typical Applications

Generally used for welding on oven parts, burners,

- Oven Parts
- Burners,
- heat treatment equipment,
- cement works,
- moulds,
- transport and storage tanks of liquid gas
- Joining dissimilar combinations of steels



Girth Gear Crack Repairs

Welding Parameters

Current Type and Polarity : AC/DC(+)

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

PHILARK ALLOYS

REGD. OFFICE & WORKS: E 37, UPSIDC, MG ROAD, HAPUR, UP



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