

# Finalloys

## The Final Welding Solution



FINALLOY ANI - 990 AC - DC (Reverse)

**OUTSTANDING  
UNIVERSAL INCONEL  
625 ELECTRODES  
TEMPERATURES  
1050°C TO -196°C  
ANI-990**

### SPECIAL FEATURES

- A Niobium bearing, all position Inconel electrode for joining high temperature cryogenic steel and nickel.
- Extremely easy slag removal.
- Phenomenal physical properties.
- Excellent out of position
- Performs unusually well on AC current.

### INTERNATIONAL CLASSIFICATIONS

AWS /ASME A 5.11 E NiCrFe-3 EN/ISO  
14172: E-Ni6082 NiCr20Mn3Nb  
DIN 1736: EL-NiCr15FeMn  
NFA 81-347: EF 20.70 NiCrMnFe B 20 BH

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PRODUCT OF USA

# OUTSTANDING UNIVERSAL INCONEL ELECTRODES

## APPLICATIONS

For joining and cladding all types of nickel alloys, stainless steels & dissimilar combinations Inconel to Monel, S. S, C. S, etc.

Ideal for the petroleum, fertilizer & Chemical industries - Furnaces, Heat Exchangers & other high temperature applications

## MECHANICAL PROPERTIES OF 990

- Tensile strength 100,000 PSI (700 MPa)
- Yield Strength 60,000 PSI (420 MPa)
- Elongation 43%

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Si	S	P	Cr	Nb	Fe	Co	Cu	Ta	Ti	Ni
.04	6.0	.40	.005	.01	16.5	2.0	6.0	.12	.1	1.3	.1	bal

**FLUX COLOR:** Gray – Tan

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Positive (+), AC

Diameter	3/32(2.5)	1/8(3.25)
Minimum Amperage	50	70
Maximum Amperage	70	95

## DEPOSITION RATES:

Diameter (mm)	Length (mm)	Weld metal/ Electrode	Electrodes per kg of weld metal	Arc Time of deposition min/kg	Amperage Setting	Recovery Rate
3/32(2.5)	12" (300)	10.5 kg	95	82	60	105%
1/8 (3.25)	14" (350)	22kg	47	53	90	105%

## Approximate Electrode Packaging & Dimension

Diameter (mm)	3/32(2.5)	1/8 (3.25)
Length (mm)	12" (300)	14" (350)
Electrodes / lb	24	13
Electrode kg	53	28

## Finalloys (FZE)

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UNITED ARAB EMIRATES



Finalloy ANI-990