

The **XUPER 660 NH Welding Electrodes** from **Metals And Welding Specialities** are engineered to deliver superior performance in high-temperature and wear-resistant environments. Designed for welding materials corresponding to **UNS N06600** and conforming to **ASTM Grade ERNiCr-3**, these electrodes are widely recognized under the **Universal Standard: AWS A5.11 ENiCrFe-3**. They provide exceptional metallurgical stability, corrosion resistance, and mechanical strength, making them an ideal choice for critical applications where durability under heat and oxidation stress is essential.



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Manufactured with advanced coating technology, **XUPER 660 NH Welding Electrodes** ensure a smooth, stable arc and minimal spatter, allowing for clean weld deposits with excellent bead appearance. The specially formulated nickel-chromium-iron alloy composition offers outstanding resistance to scaling and cracking even when exposed to temperatures exceeding 980°C. These electrodes are primarily used for joining and overlay welding of nickel-based alloys, stainless steels, and dissimilar metals that operate in demanding service conditions.



XUPER 660 NH Welding Electrodes, XUPER 660 NH Welding Electrodes Manufacturers, XUPER 660 NH Welding Electrodes Suppliers, XUPER 660 NH Welding Electrodes Stockists, XUPER 660 NH Welding Electrodes Exporters

In industrial settings such as power generation, petrochemical processing, and aerospace manufacturing, the **XUPER 660 NH** electrodes demonstrate unmatched reliability. Their strong metallurgical bonding properties make them suitable for components like turbine blades, valves, heat exchangers, and furnace equipment that must endure both thermal cycling and corrosive atmospheres. The electrodes' excellent wetting characteristics and slag removability also enhance weld efficiency, reducing downtime and post-weld cleaning effort.

Each batch of **XUPER 660 NH Welding Electrodes** is produced under stringent quality control to guarantee consistency in mechanical properties and chemical composition. Their high nickel content ensures structural integrity in welded joints, while the chromium component strengthens oxidation resistance, preventing material degradation over time. This balance of elements results in superior tensile strength, elongation, and impact resistance even after prolonged exposure to high temperatures.



XUPER 660 NH Welding Electrodes in India, XUPER 660 NH Welding Electrodes Manufacturers in India, XUPER 660 NH Welding Electrodes Suppliers in India, XUPER 660 NH Welding Electrodes Stockists in India, XUPER 660 NH Welding Electrodes Exporters in India

Whether used for new fabrication or repair welding, **XUPER 660 NH** provides the dependability and longevity professionals expect from premium-grade welding consumables. Backed by the expertise of **Metals And Welding Specialities**, these electrodes deliver exceptional weld quality across both manual and mechanized processes, ensuring confidence in every weld joint. For industries where safety, performance, and endurance are non-negotiable, XUPER 660 NH stands out as the electrode of choice.

Specification XUPER 660 NH Welding Electrodes



Parameter	Value
Electrode Type	Moisture-resistant, low hydrogen, non-hygroscopic coating
Application / Suitable for	Low alloy steels, medium carbon steels, sulphur-bearing steels, structural & high tensile steels
Tensile Strength	57 kg/mm ² (≈ 81,000 psi)
Current Type	AC / DC+ (DCEP)
Recommended Current Ranges (I-Range)	2.50 mm: 70-80 A 3.15 mm: 120-135 A 4.00 mm: 150-165 A 5.00 mm: 185-200
Alternate Current Range (II-Range)	2.50 mm: 60-70 A 3.15 mm: 100-115 A 4.00 mm: 135-150 A 5.00 mm: 165-185

Typical Applications

Crane jibs, frames, truck chassis, heavy equipment maintenance, structural components

Equivalent Grade Of XUPER 660 NH Welding Electrodes



Xuper	AWS Classification	EN ISO	DIN Standard	Werkstoff No.	UTP	Böhler	ESAB	Lincoln Electric	Thermanit
XUPER 660 NH	E NiCrFe-3	E Ni 6082	~2.4806	2.4806	UTP 82	FOX NIBAS 70/20	OK NiCr-3	Techalloy 182	Thermanit Nicro 82

XUPER 660 NH Welding Electrodes Parameters



Parameter	Value / Range
Current / Polarity	AC / DCEP (+)
Tensile Strength (typical)	88,000 psi (~ 607 MPa)
Hardness (as deposited)	HRB ~ 95
Hardness (after work-hardening)	~ HRC 30
Amperage – A Range (heavy / multipass)	1/8" (3.2 mm): 140 – 180 A 5/32" (4.0 mm): 180 – 250 A
Amperage – B Range (moderate)	1/8" (3.2 mm): 90 – 130 A 5/32" (4.0 mm): 120 – 160 A
Recommended Weave / Technique	Weaving limited to 1½ × electrode diameter
Maximum Preheat / Heat Limit	Do not heat 12 % Mn steel over 400 °F (204 °C)
Typical Hardness (alternative source)	As deposited: HRB 80–90 Work hardened: HRC 28–32

People Also Searched

XUPER 660 NH electrode specification, UNS N06600 welding electrode, ASTM ERNiCr-3 electrode, AWS A5.11 ENiCrFe-3, nickel alloy welding electrodes, Inconel 600 welding rods, heat-resistant electrodes, high-temperature welding materials, corrosion-resistant electrodes, nickel-chromium-iron electrode, dissimilar metal welding electrodes, overlay welding electrodes, furnace repair electrodes, turbine welding electrodes, valve repair electrodes, petrochemical welding materials, aerospace nickel electrodes, Inconel electrode suppliers, ENiCrFe-3 welding rod properties, high-strength nickel electrodes, stainless steel to Inconel welding, NiCrFe alloy electrodes, oxidation-resistant welding rods, nickel-based filler metals, superalloy welding electrodes, heat exchanger welding consumables, industrial welding electrodes, AWS A5.11 specification, ERNiCr-3 chemical composition, UNS N06600 material equivalent, NiCrFe-3 electrode datasheet, welding rods for dissimilar metals, high-temperature overlay electrodes, nickel-based coated electrodes, premium welding consumables, Metals And Welding Specialities electrodes, XUPER brand electrodes, wear-resistant welding solutions.