

OK NiCrMo-13

OK NiCrMo-13 is suitable for welding Ni base materials such as Alloy 59, Hastelloy C-276, Inconel 625 and Incoloy 825. It can also be used for welding superaustenitic steels type AISI/ASTM S31254 and S32654. The weld metal provides very good resistance against pitting- and chloride ion stress corrosion cracking.

Specifications

Classifications	SFA/AWS A5.11 : ENiCrMo-13 EN ISO 14172 : E Ni 6059 (NiCr23Mo16)
------------------------	---

Welding Current	DC+
Ferrite Content	FN 0
Alloy Type	Ni-based CrMo
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	430 MPa (62 ksi)	770 MPa (112 ksi)	40 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-196 °C (-321 °F)	60 J (44 ft-lb)
As Welded	-60 °C (-76 °F)	70 J (52 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Fe
0.013	0.17	0.16	61	22.6	15.2	0.6

Deposition Data

Diameter	Current	Voltage	Deposition Efficiency (%)	Burn-off Time /Electrode	Deposition Rate @ 90% I max
2.5 x 300.0 mm (0.098 x 11.8 in.)	50-70 A	25 V	60 %	50 sec	0.8 kg/h (1.8 lbs/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	60-90 A	25 V	62 %	63 sec	1.2 kg/h (2.6 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	80-120 A	27 V	62 %	81 sec	1.4 kg/h (3.1 lbs/h)