

OK Tigrod NiCrMo-3

Bare corrosion and heat-resisting Ni-Cr-Mo rods for welding of high alloyed heat-resisting and corrosion resisting materials, 9%Ni-steels and similar steels with high notch toughness at low temperatures. Also for joining of dissimilar metals of the types mentioned. The weld metal has very good mechanical properties at high and low temperatures. Good resistance to pitting and stress corrosion.

Specifications

Classifications	SFA/AWS A5.14 : ERNiCrMo-3 EN ISO 18274 : S Ni 6625
Approvals	BV : ERNiCrMo-3 DNV-GL : 2.4 mm NAKS/HAKC : 1.6-2.4 mm VdTÜV : 12460

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Alloyed nickel (Ni + 22 % Cr + 9 % Mo - 3.5 % Nb)
Shielding Gas	I1, I3, R1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	550 MPa (80 ksi)	780 MPa (113 ksi)	40 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-196 °C (-321 °F)	100 J (74 ft-lb)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Fe	Nb+Ta
0.02	0.04	0.06	Bal	22.7	8.6	0.3	3.5