

OK Autrod NiCrMo-4

OK Autrod NiCrMo-4 is a corrosion and heat resistant, nickel-chromium wire welding of high alloyed steel, heat resistant steel, corrosion resistant steel, 9Ni steels and similar steels with high notch toughness at low temperatures. Good resistance to stress corrosion.

Specifications

Classifications	SFA/AWS A5.14 : ERNiCrMo-4 EN ISO 18274 : S Ni 6276 (NiCr15Mo16Fe6W4)
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Alloy Type	Nickel alloy - 16% Cr - 16% Mo - 5% Fe - 3.5 % W - Low C
Shielding Gas	M12 (EN ISO 14175)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	W	Fe
0.01	0.45	0.05	Bal.	15.5	16.1	3.5	5.8

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	100-200 A	21-27 V	6.0-13.0 m/min	2.5-5.5 kg/h
1.2 mm	160-280 A	24-30 V	6.0-10.0 m/min	3.6-6.0 kg/h