

OK NiCrMo-5

OK NiCrMo-5 deposits an all weld metal that is similar to AWS classification ENiCrMo-5. The all weld metal consists of a Ni-Cr-Mo-W alloy of Hastelloy C type. The weld metal is tough and work hardens. The high temperature properties regarding tensile strength, hardness, thermal shock and scaling are good. It is resistant to damp chlorine gas and to hydrochloric-, nitric-, sulphuric- and phosphoric acids at room temperature. Typical applications and welding procedures recommendations are given under the heading "Other Data".

Specifiche

Classificazioni	EN 14700 : E Z Ni2
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Corrente di saldatura	DC+, AC
Tipo di lega	Nickel alloy
Tipo di rivestimento	Rutile Basic

Proprietà tipiche

Stato	Resistenza allo snervamento	Resistenza alla trazione	Allungamento
ISO			
Come saldato	515 MPa	750 MPa	17 %

analisi tipica del deposito

C	Mn	Si	Ni	Cr	Mo	W	Fe
0.05	0.9	0.5	57.5	15.5	16.4	3.5	5.5

Dati deposito

Diametro	Amp	Volt	Efficienza (%)	Tempo di fusione per elettrodo al 90% I max	Tasso di deposito al 90% I max
2.5 x 300.0 mm	65-110 A	18 V	61 %	62 sec	1.1 kg/h
3.2 x 350.0 mm	110-150 A	18 V	63 %	86 sec	1.6 kg/h
4.0 x 350.0 mm	160-200 A	20 V	64 %	89 sec	2.3 kg/h
5.0 x 350.0 mm	190-250 A	20 V	65 %	106 sec	3.1 kg/h