

OK Autrod NiCrMo-13

A continuous solid Ni-Cr-Mo electrode for welding of high alloyed Ni-base materials, 9 %Ni steel and super austenitic steels of type 20Cr-25Ni with 4-6 % Mo. Can also be used for welding carbon steel to Ni base steel. The weld metal has a very good toughness and is corrosion resistant over a wide range of applications in oxidizing and reducing media.

Specifications

Classifications	SFA/AWS A5.14 : ERNiCrMo-13 EN ISO 18274 : S Ni 6059 (NiCr23Mo16)
Approvals	VdTÜV : 12662 (MV)

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

Alloy Type	Alloyed nickel (Ni + 23 % Cr + 16 % Mo)
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Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	500 MPa	750 MPa	40 %
As Welded	500 MPa	700 MPa	42 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
As Welded	-110 °C	120 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Al	Fe
0.01	0.2	0.1	Bal	23.0	16.0	0.3	1.0

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Mo	Al	Co	Fe
0.002	0.15	0.03	0.002	0.003	22.7	15.4	0.15	0.02	0.5

Deposition Data

Diameter	Amps	Volts	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
1.6 mm	200-350 A	25-32 V	4.0-8.0 m/min	4.3-8.6 kg/h