

OK NiCrMo-13

OK NiCrMo-13 is suitable for welding Ni base materials such as Alloy 59, Hasteloy 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)
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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	770 MPa	40 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-196 °C	60 J
As Welded	-60 °C	70 J

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	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	50-70 A	25 V	60 %	50 sec	0.8 kg/h
3.2 x 350.0 mm	60-90 A	25 V	62 %	63 sec	1.2 kg/h
4.0 x 350.0 mm	80-120 A	27 V	62 %	81 sec	1.4 kg/h