

## OK Tigrod NiCrMo-13

Bare Ni-Cr-Mo rods 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

|                        |                                                                      |
|------------------------|----------------------------------------------------------------------|
| <b>Classifications</b> | SFA/AWS A5.14 : ERNiCrMo-13<br>EN ISO 18274 : S Ni 6059 (NiCr23Mo16) |
| <b>Approvals</b>       | VdTÜV : 12663 (MV)                                                   |

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

|                   |                                         |
|-------------------|-----------------------------------------|
| <b>Alloy Type</b> | Alloyed nickel (Ni + 23 % Cr + 16 % Mo) |
|-------------------|-----------------------------------------|

### Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|-----------|----------------|------------------|------------|
| As Welded | 500 MPa        | 750 MPa          | 40 %       |

### Typical Charpy V-Notch Properties

| Condition | Testing Temperature | 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 |