

OK Autrod NiFeCr-1

OK Autrod NiFeCr-1 is developed for overlay welding of low alloy steel pipes in the oil and gas industry. OK Autrod NiFeCr-1 can also be used to join 825 and materials of similar chemical composition using GTAW and GMAW.

Specifications

Classifications	SFA/AWS A5.14 : ERNiFeCr-1 EN ISO 18274 : S Ni 8065
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Alloy Type	Nickel alloy (22% Fe, 22% Cr, 3% Mo)
Shielding Gas	I1, I3 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	350 MPa (51 ksi)	560 MPa (81 ksi)	48 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-196 °C (-321 °F)	190 J (141 ft-lb)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Ti	Fe
0.01	0.5	0.3	Bal	21	3.0	2.3	0.7	24

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.14 mm (0.045 in.)	130-240 A	22-28 V	6.0-12.0 m/min (236-472 in./min)	3.0-5.7 kg/h (6.6-12. lbs/h)