

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 oxidising and reducing media.

Classifications Wire Electrode:	SFA/AWS A5.14:ERNiCrMo-13, EN ISO 18274:S Ni 6059 (NiCr23Mo16)
Approvals:	VdTUV 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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Typical Tensile Properties

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

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	61.0	23.0	16.0	0.3	1.0

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	100-200 A	21-27 V	6-13 m/min	2,5-5,5 kg/h
1.2 mm	160-280 A	24-30 V	6-10 m/min	3,6-6 kg/h
1.6 mm	200-350 A	25-32 V	4-8 m/min	4,3-8,6 kg/h