

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.

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	-60 °C	70 J
As welded	-196 °C	60 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	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
3.2 x 350 mm	60-90 A	27 V	0.61	46	58 s	3.95 kg/h