OK Tigrod NiCrMo-13

Bare Ni-Cr-Mo rods for welding of high alloyed Ni-base materials, 9% Ni steel and super austenic 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.

Classifications Wire Electrode:	SFA/AWS A5.14:ERNiCrMo-13, EN ISO 18274:S Ni 6059 (NiCr23Mo16)
Approvals:	VdTÜV 12663 (MV)

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

Alloy Type:	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	61.0	23.0	16.0	0.3	1.0

OK Tigrod NiCu-7

Bare nickel based welding rods alloyed with 30% Cu for welding of base materials of the same type. Can also be used to join these alloys to steel. The weld metal has good resistance to flowing seawater and has high strength and toughness over a rather wide temperature range. Has also good resistance to hydrofluoric acid, sulfuric acid, alkalis etc. Can be used for welding of similar types of base materials which are age-hardenable with small additions of Ti and Al.

Classifications Wire Electrode:	SFA/AWS A5.14:ERNiCu-7, EN ISO 18274:S Ni 4060 (NiCu30Mn3Ti)
Approvals:	VdTÜV 12661 (MV), VdTÜV 12669 (FP)

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

Alloy Type:	Alloyed nickel (Ni + 30 % Cu + 2 % Ti + 2 % Fe)

Typical Wire Composition %								
C	**Mn**	**Si**	**Ni**	**Al**	**Cu**	**Fe**	**Nb+Ta**	**Ti**
0.03	3	0.3	64	0.03	28	2	< 0.5	2