

OK NiCrFe-2



Nickel based electrode for welding Inconel 600 and similar alloys, cryogenic steels (e.g. 9% and 5% Ni steel), martensitic to austenitic steels, dissimilar steels, heat resisting steel castings of limited weldability etc. Good weldability in all positions, including overhead.

Classifications:	SFA/AWS A5.11:ENiCrFe-2, EN ISO 14172:E Ni 6133 (NiCr16Fe12NbMo)
Approvals:	ABS

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

Welding Current:	DC+
Ferrite Content:	FN 0
Alloy Type:	Nickel alloy
Coating Type:	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As welded	420 MPa	660 MPa	45 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As welded	20 °C	110 J
As welded	-196 °C	90 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Fe	Nb
0.03	2.7	0.5	69	16.1	1.9	7.7	1.9

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
2.5 x 300 mm	50-80 A	22 V	0.63	91.0	45 s	0.90 kg/h
3.2 x 350 mm	70-105 A	23 V	0.62	57.0	57 s	1.30 kg/h
4.0 x 350 mm	95-140 A	24 V	0.65	31.0	58 s	2.10 kg/h