OK NiCrMo-3

Ni-based CrMoNb electrode for welding of Ni-alloys of the same or similar type as e.g. Inconel 625, for welding of 5% and 9% Ni steel. The electrode is very suitable for welding of 254 SMO, i.e. UNS S31254 steel.

Classifications:	SFA/AWS A5.11:ENiCrMo-3, EN ISO 14172:E Ni 6625 (NiCr22Mo9Nb)
Approvals:	CE EN 13479, DNV -(H5), VdTÜV 12414

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

Welding Current:	DC+
Ferrite Content:	FN 0
Alloy Type:	Ni-based CrMoNb
Coating Type:	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	500 MPa	780 MPa	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	20 °C	70 J
As welded	-196 °C	50 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Fe	Nb
0.03	0.2	0.4	62.8	21.7	9.3	2.0	3.3

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	55-75 A	23 V	0.55	100	40 s	0.9 kg/h
3.2 x 350 mm	65-100 A	25 V	0.56	49	52 s	1.4 kg/h
4.0 x 350 mm	80-140 A	27 V	0.58	33	57 s	1.9 kg/h
5.0 x 350 mm	120-170 A	24 V	0.58	21	72 s	2.1 kg/h