

OK NiCrMo-5



OK NiCrMo-5 deposits an all weld metal that is similar to AWS classification ENiCrMo-5. The all weld metal consists of a Ni-Cr-Mo-W alloy of Hastelloy C type. The weld metal is tough and work hardens. The high temperature properties regarding tensile strength, hardness, thermal shock and scaling are good. It is resistant to damp chlorine gas and to hydrochloric-, nitric-, sulphuric- and phosphoric acids at room temperature.

Classifications:	EN 14700:E Z Ni2
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Welding Current:	DC+, AC
Alloy Type:	Nickel alloy
Coating Type:	Rutile Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	515 MPa	750 MPa	17 %

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Fe	W
0.05	0.9	0.5	57.5	15.5	16.4	5.5	3.5

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	65-110 A	18 V	0.61	56	62 s	1.1 kg/h
3.2 x 350 mm	110-150 A	18 V	0.63	28	86 s	1.6 kg/h
4.0 x 350 mm	160-200 A	20 V	0.64	19	89 s	2.3 kg/h
5.0 x 350 mm	190-250 A	20 V	0.65	11	106 s	3.1 kg/h