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.

Specifications	
Classifications	SFA/AWS A5.11 : ENiCrMo-3 EN ISO 14172 : E Ni 6625 (NiCr22Mo9Nb)
Approvals	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	520 MPa (75 ksi)	820 MPa (119 ksi)	38 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	20 °C (68 °F)	70 J (52 ft-lb)
As Welded	-196 °C (-321 °F)	65 J (48 ft-lb)

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**Nb**	**Fe**
0.03	0.2	0.4	62.8	21.7	9.3	3.3	2.0

Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
2.5 x 300 mm (0.098 x 11.8 in.)	55-75 A	23 V	55 %	40 sec	0.9 kg/h (2.0 lbs/h)
3.2 x 350 mm (1/8 x 13.8 in.)	65-100 A	25 V	56 %	52 sec	1.4 kg/h (3.1 lbs/h)
4.0 x 350 mm (5/32 x 13.8 in.)	80-140 A	27 V	58 %	57 sec	1.9 kg/h (4.2 lbs/h)
5.0 x 350 mm (0.197 x 13.8 in.)	120-170 A	24 V	58 %	72 sec	2.1 kg/h (4.6 lbs/h)