

OK Tigrod NiCrMo-3

Bare corrosion and heat-resisting Ni-Cr-Mo rods for welding of high alloyed heat-resisting and corrosion resisting materials, 9%Ni-steels and similar steels with high notch toughness at low temperatures. Also for joining of dissimilar metals of the types mentioned. The weld metal has very good mechanical properties at high and low temperatures. Good resistance to pitting and stress corrosion.

Specifications	
Classifications	SFA/AWS A5.14 : ERNiCrMo-3 EN ISO 18274 : S Ni 6625
Approvals	CE : EN 13749 DNV-GL : 2.4 mm NAKS/HAKC : 2.0-2.4 mm VdTÜV : 12460

Alloy Type	Alloyed nickel (Ni + 22 % Cr + 9 % Mo - 3.5 % Nb)
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	550 MPa	780 MPa	40 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	-196 °C	100 J

Typical Wire Composition %							
C	Mn	Si	Ni	Cr	Mo	Fe	Nb+Ta
0.02	0.04	0.06	bal	22.7	8.6	0.3	3.5