OK Tigrod NiCrMo-3

Bare corrosion and heat-resisting Ni-Cr-Mo rod for welding of high alloyed heat-resisting and corrosion resisting materials, 9%Ni-steels and similar steels with high notch toughness at low temperatures. The filler metal is also used for welding of dissimilar joints containing non- and low alloyed steel. The weld metal has good mechanical properties at high and low temperatures. Good resistance to pitting corrosion and stress corrosion cracking.

Specifications	
Classifications	SFA/AWS A5.14 : ERNiCrMo-3 EN ISO 18274 : S Ni 6625
Approvals	BV : ERNiCrMo-3 DNV : 2.4 mm VdTÜV : 12460

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

Alloy Type	Alloyed nickel (Ni + 22% Cr + 9% Mo - 3.5% Nb)
Shielding Gas	I1, I3, R1 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	550 MPa (80 ksi)	780 MPa (113 ksi)	40 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
As Welded	-196 °C (-321 °F)	100 J (74 ft-lb)

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Al**	**Cu**
0.009	<0.05	0.08	0.001	0.004	63	22.1	9.1	0.09	<0.01

Typical Weld Metal Analysis %		
Ti	**Fe**	**Nb+Ta**
0.18	1.41	3.47

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