OK Autrod NiCr-3

Continuous solid Ni-Cr wire 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 stress corrosion.

Classifications Wire Electrode	SFA/AWS A5.14 : ERNiCr-3 EN ISO 18274 : S Ni 6082 (NiCr20Mn3Nb)
Approvals	VdTÜV 12656 (MV) VdTÜV 12666 (FP)

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

Alloy Type	Alloyed nickel (Ni + 20 % Cr + 3 % Mn + 2.5 % Nb)
Shielding Gas	I1, I3 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	400 MPa (58 ksi)	650 MPa (94 ksi)	40 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	150 J (111 ft-lb)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Fe	Nb+Ta
0.04	3.0	0.2	bal	20.0	1.3	2.5

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm (0.030 in.)	70-190 A	20-27 V	5.0-18.0 m/min (197-709 in./min)	1.3-4.8 kg/h (2.9-10. lb/h)
1.0 mm (0.040 in.)	100-200 A	21-27 V	6.0-13.0 m/min (236-512 in./min)	2.5-5.5 kg/h (5.5-12. lb/h)
1.2 mm (0.047 in.)	160-280 A	24-30 V	6.0-10.0 m/min (236-394 in./min)	3.6-6.0 kg/h (7.9-13. lb/h)

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