

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.

Typical applications and welding procedures recommendations are given under the heading "Other Data".

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 (75 ksi)	750 MPa (109 ksi)	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	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 300.0 mm (0.098 x 11.8 in.)	65-110 A	18 V	56	62 sec	61 %	1.1 kg/h (2.4 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	110-150 A	18 V	28	86 sec	63 %	1.6 kg/h (3.5 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	160-200 A	20 V	19	89 sec	64 %	2.3 kg/h (5.1 lb/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	190-250 A	20 V	11	106 sec	65 %	3.1 kg/h (6.8 lb/h)