

## OK Tigrod NiCr-3

Bare Ni-Cr 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 stress corrosion.

<b>Classifications Wire Electrode</b>	SFA/AWS A5.14 : ERNiCr-3 EN ISO 18274 : S Ni 6082 (NiCr20Mn3Nb)
<b>Approvals</b>	NAKS/HAKC 2.4 mm VdTUV 19531

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

<b>Alloy Type</b>	Alloyed nickel (Ni + 20 % Cr + 3 % Mn + 2.5 % Nb)
<b>Shielding Gas</b>	I1, R1 (EN 439)

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	220 J (163 ft-lb)
As Welded	-196 °C (-321 °F)	180 J (133 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