

OK NiCrMo-3



Ni-based CrMoNb electrode for welding of Ni-alloys of the same or similar type as e.g. Inconel 625, for welding of 5% and 9% Ni steel. The electrode is very suitable for welding of 254 SMO, i.e. UNS S31254 steel.

Classifications	SFA/AWS A5.11 : ENiCrMo-3 EN ISO 14172 : E Ni 6625 (NiCr22Mo9Nb)
Approvals	CE EN 13479 DNV-GL -H5 NAKS/HAKC 2.5-4.0 mm VdTUV 12414

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

Welding Current	DC+
Ferrite Content	FN 0
Alloy Type	Ni-based CrMoNb
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	500 MPa (73 ksi)	780 MPa (113 ksi)	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C (68 °F)	70 J (52 ft-lb)
As Welded	-196 °C (-321 °F)	50 J (37 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Nb	Fe
0.03	0.2	0.4	62.8	21.7	9.3	3.3	2.0

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.)	55-75 A	23 V	100	40 sec	55 %	0.9 kg/h (2.0 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	65-100 A	25 V	49	52 sec	56 %	1.4 kg/h (3.1 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	80-140 A	27 V	33	57 sec	58 %	1.9 kg/h (4.2 lb/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	120-170 A	24 V	21	72 sec	58 %	2.1 kg/h (4.6 lb/h)