OK NiCrFe-2

Nickel based electrode for welding Inconel 600 and similar alloys, cryogenic steels (e.g. 9% and 5% Ni steel), martensitic to austenitic steels, dissimilar steels, heat resisting steel castings of limited weldability etc. Good weldability in all positions, including overhead.

Classifications	SFA/AWS A5.11 : ENiCrFe-2 EN ISO 14172 : E Ni 6133 (NiCr16Fe12NbMo)
Approvals	ABS

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

Welding Current	DC+
Ferrite Content	FN 0
Alloy Type	Nickel alloy
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	420 MPa (61 ksi)	660 MPa (96 ksi)	45 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	20 °C (68 °F)	110 J (81 ft-lb)
As Welded	-196 °C (-321 °F)	90 J (67 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Nb	Fe
0.03	2.7	0.5	69	16.1	1.9	1.9	7.7

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.)	50-80 A	22 V	91.0	45 sec	63 %	0.9 kg/h (2.0 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	70-105 A	23 V	57.0	57 sec	62 %	1.3 kg/h (2.9 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	95-140 A	24 V	31.0	58 sec	65 %	2.1 kg/h (4.6 lb/h)

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