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.

Specifications	
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+
Alloy Type	Nickel alloy
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
2.PWHT 4.5 hour(s) 982 °C	321 MPa	668 MPa	50 %
As Welded	420 MPa	660 MPa	45 %
4.PWHT 4.5 hour(s) 982 °C	233 MPa	515 MPa	46 %
1.PWHT 4.5 hour(s) 982 °C	329 MPa	673 MPa	50 %
3.PWHT 4.5 hour(s) 982 °C	239 MPa	526 MPa	44 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-196 °C	90 J
As Welded	20 °C	110 J
2.PWHT	-60 °C	118 J
1.PWHT	-60 °C	122 J

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	Deposition Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate @ 90% I max
2.5 x 300.0 mm	50-80 A	22 V	63 %	45 sec	0.9 kg/h
3.2 x 350.0 mm	70-105 A	23 V	62 %	57 sec	1.3 kg/h
4.0 x 350.0 mm	95-140 A	24 V	65 %	58 sec	2.1 kg/h