

## OK NiCrMo-13

OK NiCrMo-13 is suitable for welding Ni base materials such as Alloy 59, Hasteloy C-276, Inconel 625 and Incoloy 825. It can also be used for welding superaustenitic steels type AISI/ASTM S31254 and S32654. The weld metal provides very good resistance against pitting- and chloride ion stress corrosion cracking.

### Specifications

<b>Classifications</b>	SFA/AWS A5.11 : ENiCrMo-13 EN ISO 14172 : E Ni 6059 (NiCr23Mo16)
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<b>Welding Current</b>	DC+
<b>Ferrite Content</b>	FN 0
<b>Alloy Type</b>	Ni-based CrMo
<b>Coating Type</b>	Basic

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	430 MPa	770 MPa	40 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	-196 °C	60 J
As Welded	-60 °C	70 J

### Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Fe
0.013	0.17	0.16	61	22.6	15.2	0.6

### 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	50-70 A	25 V	60 %	50 sec	0.8 kg/h
3.2 x 350.0 mm	60-90 A	25 V	62 %	63 sec	1.2 kg/h
4.0 x 350.0 mm	80-120 A	27 V	62 %	81 sec	1.4 kg/h