

OK Autrod 19.82 GMAW

ERNiCrMo-3

Description

A continuous, solid, corrosion- and heat-resistant, Ni-Cr electrode for welding high-alloyed heat-resistant and corrosion-resistant materials, 9% Ni steels and similar steels with high notch toughness at low temperatures. It is also suitable for joining dissimilar metals of the types mentioned above. The weld metal has very good mechanical properties at high and low temperatures. Good resistance to pitting and stress corrosion.

Welding current

DC(+)

Classifications

SFA/AWS A5.14 ERNiCrMo-3
EN ISO 18274 S Ni 6625
(NiCr22Mo9Nb)

Wire composition

C	Si	Mn	Cr	Ni	Mo	Cu	Al	Ti	Fe
<0.1	<0.5	<0.5	21.5	>60.0	9.0	<0.5	<0.4	<0.4	<2.0

Typical mech. properties all weld metal

Yield stress, MPa	500
Tensile strength, MPa	780
Elongation, %	40

Charpy V

Test temps, °C	Impact values, J
+20	130
-105	120
-196	110

Approvals

UDT DIN 1736
VdTÜV

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
0.8	5-18	70-190	20-27	1.3-4.5
1.0	6-13	100-200	21-27	2.3-5.1
1.2	6-10	160-280	24-30	3.4-5.6
1.6	4-8	200-350	25-32	4.0-8.0