



# Product Data Sheet

G 'Gas-shielded metal-arc welding'

## OK Autrod NiCr-3

Prepared by Mikael Mimer	Qualified by Tero Tolonen	Approved by Mikael Mimer	Reg no EN006317	Cancelling EN006163	Reg date 2013-12-02	Page 1 (2)
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### REASON FOR ISSUE

A comment clarifying "Others" added

### GENERAL

Continuous solid Ni-Cr wire for welding of high alloyed heat-resisting and corrosion resisting materials, 9%Ni-steels and similar steels with high notch toughness at low temperatures. Also for joining of dissimilar metals of the types mentioned. The weld metal has very good mechanical properties at high and low temperatures. Good resistance to stress corrosion.

**Shielding Gas:** I1, I3 (EN ISO 14175)

**Alloy Type:** Alloyed nickel (Ni + 20 % Cr + 3 % Mn + 2.5 % Nb)

### CLASSIFICATIONS Wire Electrode

### APPROVALS

SFA/AWS A5.14	ERNiCr-3	VdTÜV	12656 (MV)
EN ISO 18274	S Ni 6082 (NiCr20Mn3Nb)	VdTÜV	12666 (FP)

### CHEMICAL COMPOSITION

#### Wire/Strip (%)

	Min	Max
C		0.05
Si		0.25
Mn	2.50	3.50
P		0.010
S		0.010
Cr	18.0	22.0
Ni	67.0	
Co		0.05
Cu		0.07
Ti		0.70
Fe		1.5
Nb+Ta	2.30	3.00
Others tot		0.50

Comments:  
Up to 20% of Nb+Ta can be Ta.  
Others tot. also include Co.

### ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	$\eta$	H	Feed			U	
	Min	Max				Min	Max	Min		Max
$\emptyset$			Nom	Nom	Min	Max	Min	Max	Min	Max
1.2	160	280	18		3,6	6	6	10	24	30

**W** = Gas consumption (l / min)

**$\eta$**  = Recovery, g weld metal / 100g wire (%)

**H** = Deposit rate (kg weld metal / hour arc time)

**Feed** = Feeding rate (m/min)

**U** = Arc voltage (V)



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### OTHER DATA

The electrode is used for welding of e.g.

Ni-alloy type:

600 (Werkstoffnr 2.4816)

9%Ni.steel: X 8Ni9

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