Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod NiCrMo-3

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
Fredrik Wedberg	Tero Tolonen	Jay A Coubrough	EN006806	EN006316	2015-08-07	1 (2)

REASON FOR ISSUE

Correction of minimum and typical impact values

GENERAL

Bare corrosion and heat-resisting Ni-Cr-Mo rods 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 pitting and stress corrosion.

Alloy Type: Alloyed nickel (Ni + 22 % Cr + 9 % Mo - 3.5 % Nb)

CLASSIFICATIONS Wire Electrode

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

APPROVALS

DNV	For NV1.5Ni up to NV9Ni
VdTÜV	12460

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C		0.03
Si		0.20
Mn		0.30
P		0.008
S		0.005
Cr	20.0	23.0
Ni	60.0	
Mo	8.0	10.0
Cu		0.30
Al		0.30
Ti		0.30
Fe		0.5
Nb+Ta	3.15	4.15
Others tot		0.50

Comments:
Up to 20% of Nb+Ta can be Ta.

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

	As welded	
Properties	**Min**	**Typ**
Rp0.2 (MPa)	420	550
Rm (MPa)	710	780
A5 (%)	30	40
Z (%)		40
Charpy V at -196°C (J)	60	100

OTHER DATA

The rods are used for welding of e.g.
Ni-alloy type:
625 (Werkstoffnr 2.4856)
825 (Werkstoffnr 2.4858)
800 (Werkstoffnr 1.4876)
9%Ni.steel: X 8Ni9
Austenitic stainless steels:
X10NiCrAlTi 32 20 (1.4876)
X2NiCrMoCu 25 20 6 (1.4529)
X2CrNiMoCuN 20 18 6
The filler metal is also used for welding of dissimilar joints containing Non- and Low alloyed steel.