



Product Data Sheet

E 'Manual metal-arc welding'

OK NiCrMo-3

Former OK 92.45

Prepared by Mirjam Hamsten	Qualified by Tero Tolonen	Approved by Tapio Huhtala	Reg no EN006913	Cancelling EN006282	Reg date 2015-10-08	Page 1 (2)
-------------------------------	------------------------------	------------------------------	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

Approvals grades revised. CE approval added.

GENERAL

Ni-based CrMoNb electrode for welding of Ni-alloys of the same or similar type as e.g. Inconel 625, for welding of 5% and 9% Ni steel. The electrode is very suitable for welding of 254 SMO, i.e. UNS S31254 steel.

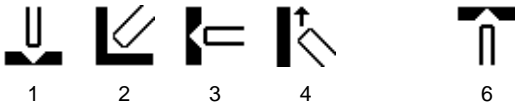
Polarity: DC+

Alloy Type: Ni-based CrMoNb

Coating Type: Basic

Ferrite Content: FN 0

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.11 ENiCrMo-3
EN ISO 14172 E Ni 6625 (NiCr22Mo9Nb)

APPROVALS

CE EN 13479
DNV -(H5)
VdTÜV 12414

APPROVAL COMMENT

DNV: For NV 1.5Ni up to NV 9Ni.

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C		0.05
Si	0.30	0.70
Mn		0.50
P		0.020
S		0.010
Cr	20.5	22.5
Ni	60.0	67.8
Mo	8.5	10.0
Nb	3.15	4.00
Cu		0.3
Al		0.4
Fe		5.0
Nb+Ta	3.15	4.00

MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO	
	Min	Typ
Rp0.2 (MPa)	420	500
Rm (MPa)	760	780
A5 (%)	30	35
Charpy V at 20°C (J)	60	70
Charpy V at -196°C (J)	40	50



Product Data Sheet

E 'Manual metal-arc welding'

OK NiCrMo-3

Former OK 92.45

Prepared by Mirjam Hamsten	Qualified by Tero Tolonen	Approved by Tapio Huhtala	Reg no EN006913	Cancelling EN006282	Reg date 2015-10-08	Page 2 (2)
-------------------------------	------------------------------	------------------------------	--------------------	------------------------	------------------------	---------------

ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 300	55	75	1.8	105	0.55	100	0.9	40	23	1,2,3,4,6
3.2 x 350	65	100	3.6	105	0.56	49	1.4	52	25	1,2,3,4,6
4.0 x 350	80	140	5.3	105	0.58	33	1.9	57	27	1,2,3,4,6
5.0 x 350	120	170	7.8	94	0.58	21	2.1	72	24	1,2,3

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)

OTHER DATA

Redrying 200°C, 2h.
