

OK Tigrod 19.81

GTAW
ERNiCrMo-13

Description

Bare Ni-Cr-Mo rod for welding high-alloyed materials of the 20Cr-25Ni type with 4-6% Mo and Ni based alloys of a similar type. It can also be welded in combination with carbon steels. The weld metal has very good corrosion resistance over a wide range of applications in oxidising and reducing media.

Welding current

DC (-)

Classifications

SFA/AWS A5.14	ERNiCrMo-13
EN ISO 18274	S Ni 6059 (NiCr23Mo16)

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo
0.002	0.03	0.15	23.0	Bal	15.7

Typical properties of all weld metal

Yield stress, Mpa	550
Tensile strength, MPa	800
Elongation, %	45

Charpy V

Test temps, °C	Impact values, J
-110	120

Approval

VdTÜV	07768(MV)
-------	-----------

Packing/Ordering Information

Part Number	Dia mm	Per Pack (kg)	Pallet Weight (kg)
198116R150	1.6	5	500
198120R150	2.0	5	500
198124R150	2.4	5	500