

OK Tigrod NiCr-3

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.

Classifications Wire Electrode:	SFA/AWS A5.14:ERNiCr-3, EN ISO 18274:S Ni 6082 (NiCr20Mn3Nb)
Approvals:	VdTÜV 12657, VdTÜV 12667

Approvals are based on factory location. Please contact ESAB for more information.

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

Condition	Yield Strength	Tensile Strength	Elongation
As welded	400 MPa	650 MPa	40 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As welded	20 °C	150 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Cu	Fe	Nb+Ta	Ti
0.04	3.0	0.2	72.50	20.0	0.01	1.3	2.5	0.35