



Product Data Sheet

S 'Submerged arc welding'

OK Autrod NiCrMo-13

Prepared by Paolo Torchiana	Qualified by Tero Tolonen	Approved by Paolo Torchiana	Reg no EN006370	Cancelling None	Reg date 2014-03-28	Page 1 (1)
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REASON FOR ISSUE

Product name change from OK Autrod 19.81 to OK Autrod NiCrMo-13.

GENERAL

OK Autrod NiCrMo-13 is a Nb-free, Ni-Cr-Mo wire for welding high-alloyed steels of the 20Cr25Ni4-6Mo type and nickel-based alloys of similar type. The wire can also be used for welding these steels with dissimilar steels. The weld metal has very good corrosion resistance in both oxidizing and reducing media. OK Autrod NiCrMo-13 can be combined with OK Flux 10.90 or OK Flux 10.16.

CLASSIFICATIONS Wire Electrode

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

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C		0.010
Si		0.10
Mn		0.5
P		0.015
S		0.005
Cr	22.0	24.0
Ni	56.0	
Mo	15.0	16.5
Co		0.3
Al	0.1	0.4
Fe		1.5
Others tot		0.50