



Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK Autrod NiCrMo-4

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REASON FOR ISSUE

Welding Parameters Revised

GENERAL

OK Autrod NiCrMo-4 is a corrosion and heat resistant, nickel-chromium wire welding of high alloyed steel, heat resistant steel, corrosion resistant steel, 9Ni steels and similar steels with high notch toughness at low temperatures. Good resistance to stress corrosion.

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.14 ERNiCrMo-4
EN ISO 18274 S Ni 6276
(NiCr15Mo16Fe6W4)

APPROVALS

Not applicable

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C		0.02
Si		0.08
Mn		1.0
P		0.020
S		0.015
Cr	14.5	16.5
Ni	50.0	
Mo	15.0	17.0
W	3.0	4.5
Co		2.5
V		0.3
Cu		0.50
Fe	4.0	7.0
Others tot		0.50

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
	Min	Max			Min	Max	Min	Max	Min	Max
\emptyset			Nom	Nom	Min	Max	Min	Max	Min	Max
1.0	100	200	15		2.5	5.5	6	13	21	27
1.2	160	280	18		3.6	6	6	10	24	30

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)