



# GULF WIRES LLC

## OK Autrod NiFeCr-1

OK Autrod NiFeCr-1 is developed for overlay welding of low alloy steel pipes in the oil and gas industry. OK Autrod NiFeCr-1 can also be used to join 825 and materials of similar chemical composition using GTAW and GMAW.

Specifications	
<b>Classifications</b>	SFA/AWS A5.14 : ERNiFeCr-1 EN ISO 18274 : S Ni 8065

<b>Alloy Type</b>	Nickel alloy (22% Fe, 22% Cr, 3% Mo)
<b>Shielding Gas</b>	I1, I3 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	350 MPa ( 51 ksi )	560 MPa ( 81 ksi )	48 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	-196 °C ( -321 °F )	190 J ( 141 ft-lb )

Typical Wire Composition %								
C	Mn	Si	Ni	Cr	Mo	Cu	Ti	Fe
0.01	0.5	0.3	Bal	21	3.0	2.3	0.7	24

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.14 mm ( 0.045 in. )	130-240 A	22-28 V	6.0-12.0 m/min ( 236-472 in./min )	3.0-5.7 kg/h ( 6.6-12. lbs/h )