

OK Ni-1

A stick electrode for joining commercially pure nickel in wrought and cast forms. Also for joining dissimilar metals such as nickel to steel, nickel to copper and copper to steel. The electrode can also be used for surfacing steel.

Specifications

Classifications	SFA/AWS A5.11 : ENi-1 EN ISO 14172 : E Ni 2061 (NiTi3)
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Welding Current	DC+
Alloy Type	Nickel-base
Coating Type	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	330 MPa	470 MPa	30 %

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Al	Ti	Fe
0.04	0.4	0.7	96	0.10	1.5	0.4

Deposition Data

Diameter	Current	Deposition Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate @ 90% I max
2.5 x 300.0 mm	70-95 A	55 %	47 sec	0.8 kg/h
3.2 x 350.0 mm	90-135 A	55 %	56 sec	1.2 kg/h