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)

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