

# OK 92.18

Type Basic special, high graphite

SMAW

ENi-CI

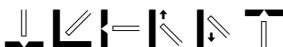
## Description

A nickel-cored electrode for welding normal grades of cast iron. The weld metal is soft and easily machinable. Deposition is performed on cold or slightly preheated material.

The electrode is suitable for joining cast iron for the rectification of casting and the repair of broken parts.

## Welding current

AC, DC+ OCV 50 V



## Classifications

SFA/AWS A5.15	ENi-CI
EN ISO 1071	E C Ni-CI 3

## Typical all weld metal composition, %

C	Si	Mn	Ni	Fe
0.9	0.7	0.6	>92.0	3.5

## Typical mech. properties all weld metal

Tensile strength, MPa	300
Hardness:	150 HB

## Approvals

Sepros UNA 409820

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	300	55-110	20	0.71	83.3	0.9	46
3.2	350	80-140	20	0.68	44.8	1.2	66
4.0	350	100-190	20	0.70	29.4	1.7	71