

# OK 92.55

Type Basic

SMAW

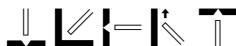
ENiCrMo-6

## Description

OK 92.55 is an all-positional, basic coated electrode which deposits a NiCr-based alloy with additions of Mo, W and Nb. The electrode is specifically designed for welding 9%Ni steels for cryogenic applications down to -196°C.

## Welding current

AC, DC+ - OCV 55 V



## Classifications

SFA/AWS A5.11	ENiCrMo-6
EN ISO 14172	E Ni 6620 (NiCr14Mo7Fe)

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	W	Nb	Cu	Fe
0.05	0.3	3.0	13.0	69	6.2	1.6	1.3	<0.3	5.0

## Typical mech. properties all weld metal

Yield stress, MPa	>430
Tensile strength, MPa	>690
Elongation A4, %	>35

## Charpy V

Test temps, °C -196	Impact values, J >70
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## Approvals

ABS ENiCrMo-6

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of elec- trodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	350	65-115	22	0.66	34	1.5	68
3.2	350	70-150	22	0.66	34	1.5	68
4.0	350	120-200	22	0.67	23	1.9	82
5.0	350	150-240	23	0.68	14	2.8	91