

OK 92.86

Type Basic

SMAW

E NiCu-7

Description

A nickel-copper electrode for welding NiCu alloys to themselves and to steels and for corrosion-resistant surfacing. The weld metal of OK 92.86 is crack resistant and ductile and meets rigorous requirements relating to corrosion resistance in sea water and in reducing and oxidising acids. OK 92.86 is used for welding corrosion-resistant monel alloys within the petroleum and ammonium sulphate industry and in power plants.

Welding current

DC+



Classifications

SFA/AWS A5.11	E NiCu-7
EN ISO 14172	E Ni 4060 (NiCu30Mn3Ti)

Typical all weld metal composition, %

C	Si	Mn	Ni	Nb	Cu	Al	Ti	Fe
0.01	0.3	2.1	66	<0.3	29	<0.5	0.2	1.6

Typical mech. properties all weld metal

Yield stress, MPa	410
Tensile strength, MPa	640
Elongation A4, %	40

Charpy V

Test temps, °C	Impact values, J
+20	100
-196	80

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	50-70	22	0.63	83	1.0	45
3.2	350	70-120	26	0.63	42	1.6	52
4.0	350	120-140	28	0.63	28	2.4	54