

OK 94.55

SMAW

Type Basic

Description

OK 94.55 is an electrode for welding silicon bronzes and certain special types of brass. It is also suitable for overlaying bearing surfaces and corrosion-resistant surfacing on steel.

Welding current

DC+



Classifications

DIN 1733	EL-CuSi3
Werkstoff	Nr.2.1461

Typical all weld metal composition, %

Si	Mn	Cu
3.0	<1.5	95.5

Typical mech. properties all weld metal

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	55-95	25	0.67	77	1.1	42
3.2	350	85-130	28	0.67	47	1.7	45
4.0	350	110-165	28	0.67	32	2.3	50