

OK 92.15

Type Basic

SMAW

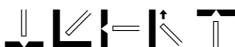
ENiCrFe-2

Description

OK 92.15 is a nickel-based electrode for welding Inconel 600 and similar alloys, cryogenic steels (e.g. 9Ni and 5Ni steels), martensitic to austenitic steels, dissimilar steels, heat-resistant steel castings with limited weldability and so on. The weldability is good in all positions, even in the overhead position.

Welding current

DC+



Classifications

SFA/AWS A5.11	ENiCrFe-2
EN ISO 14172	E Ni 6133 (NiCr16Fe12NbMo)

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Cu	Fe
<0.1	<0.75	2.3	15.5	70	1.5	2.0	<0.5	9.0

Typical mech. properties all weld metal

Yield stress, MPa	420
Tensile strength, MPa	660
Elongation A4, %	45

Charpy V

Test temps, °C	Impact values, J
+20	110
-196	90

Approvals

ABS

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	50-80	22	0.63	91	0.9	45
3.2	350	70-105	23	0.62	57	1.3	57
4.0	350	95-140	24	0.65	31	2.1	58