

# OK 92.60

SMAW

Type Basic special, high graphite ENiFe-CI

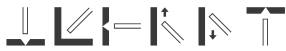
## Description

An electrode of the nickel-iron type for welding normal grades of cast iron and for joining them to steel.

The electrode has very good current-carrying capacity. The electrode produces a weld metal that is stronger and more resistant to solidification cracking than that of the nickel electrode type.

## Welding current

AC, DC+ OCV 45 V



## Classifications

SFA/AWS A5.15	ENiFe-CI
EN ISO 1071	E C NiFe-1 3

## Typical all weld metal composition, %

C	Si	Mn	Ni	Nb	Cu	Al	Fe
0.9	<0.8	0.7	52	0.2	1.0	0.3	44

## Typical mech. properties all weld metal

Yield stress, MPa	380
Tensile strength, MPa	560
Elongation A5, %	>15%
Hardness (HB):	200

## 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	60-100	22	0.70	85	0.8	45
3.2	350	80-150	23	0.70	44	1.2	56
4.0	350	100-200	23	0.70	30	1.6	59
5.0	350	150-250	23	0.70	19	2.4	66

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