

OK 92.78

Type Basic-special

SMAW

E C NiCu 1

Description

OK 92.78 is a nickel-copper electrode of the monel-alloy type for welding all types of cast iron with or without low preheat. The weld metal is easily machinable and produces a colour very similar to that of cast iron.

Welding current

AC, DC+ - OCV 45 V



Classifications

EN ISO 1071 E C NiCu 1

Typical all weld metal composition, %

C	Si	Mn	Ni	Cu	Fe
0.7	<0.2	0.9	64	32	3

Typical mech. properties all weld metal

Tensile strength, MPa	300-350
Elongation A5, %	15
Hardness (HB):	150

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	50-100	18	0.60	96	0.6	66
3.2	350	60-125	18	0.65	49	0.8	97
4.0	350	90-140	18	0.65	32	0.9	130

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