

OK Ni-1



A stick electrode for joining commercially pure nickel in wrought and cast forms. Also for joining dissimilar metals such as nickel to steel, nickel to copper and copper to steel. The electrode can also be used for surfacing steel.

| | |
|------------------------|---|
| Classifications | SFA/AWS A5.11 : ENi-1 EN ISO 14172 : E Ni 2061 (NiTi3) |
|------------------------|---|

| | |
|------------------------|-------------|
| Welding Current | DC+ |
| Alloy Type | Nickel-base |
| Coating Type | Lime Basic |

Typical Tensile Properties

| Yield Strength | Tensile Strength | Elongation |
|----------------|------------------|------------|
| ISO | | |

Typical Weld Metal Analysis %

| C | Mn | Si | Ni | Al | Ti | Fe |
|------|-----|-----|----|------|-----|-----|
| 0.04 | 0.4 | 0.7 | 96 | 0.10 | 1.5 | 0.4 |

Deposition Data

| Diameter | Current | Number of electrodes/ kg weld metal | Burn-off Time/ Electrode | Deposition Efficiency % | Deposition Rate @ 90% I max |
|--------------------------------------|----------|--|-----------------------------|-------------------------|--------------------------------|
| 2.5 x 300.0 mm (0.098 x 11.8 in.) | 70-95 A | 96 | 47 sec | 55 % | 0.8 kg/h (1.8 lb/h) |
| 3.2 x 350.0 mm (1/8 x 13.8 in.) | 90-135 A | 53 | 56 sec | 55 % | 1.2 kg/h (2.6 lb/h) |