



# Product Data Sheet

E 'Manual metal-arc welding'

# OK NiCu 1

Former OK 92.78

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by Tapio Huhtala	Reg no EN007078	Cancelling EN006248	Reg date 2016-02-17	Page 1 (2)
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## REASON FOR ISSUE

Product description revised.

## GENERAL

OK NiCu 1 is a nickel-copper cored electrode of monel type for welding normal grades of cast iron such as gray-, ductile- and malleable irons. Deposition is done on cold or slightly preheated material.

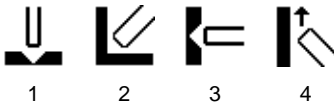
The weld metal is well machinable and provides a good colour match to that of cast iron.

**Min AC OCV:** 45

**Alloy Type:** Nickel-copper alloy

**Coating Type:** Basic Special

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

EN ISO 1071

E C NiCu 1

## APPROVALS

Not applicable

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	Min	Max
C	0.2	0.7
Si		0.2
Mn	0.7	1.1
P		0.02
S		0.02
Ni	60	67
Cu	29	35
Fe	2	4

## MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO
	As welded Typ
Rm (MPa)	300-350
A5 (%)	15

## Comments:

Hardness: 140-160 HB.



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## ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 300	50	100	1.7	95	0.60	96.0	0.60	66	18	1,2,3,4
3.2 x 350	60	125	3.2	95	0.65	49.0	0.80	97	18	1,2,3,4
4.0 x 350	90	140	4.8	95	0.65	32.0	0.90	130	18	1,2,3,4

**W** = Weight (kg / 100 electrodes)

**η** = Efficiency (g weld metal x 100 / g core wire)

**N** = Effective value (kg weld metal / kg electrodes)

**B** = Changes (number of electrodes / kg weld metal)

**H** = Deposit rate at 90% of max current (kg weld metal / hour arc time)

**T** = Fusion time at 90% of max current (s / electrode)

**U** = Arc voltage (V)

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## OTHER DATA

Redrying 80 °C, 2h.

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