

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

Typical Tensile Properties

Yield Strength	Tensile Strength	Elongation
ISO		
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)