

OK 92.55

An all position basic coated electrode depositing a nickel chromium based alloy with additions of molybdenum, tungsten and niobium. The electrode is especially designed for welding of 9% nickel steels for cryogenic applications down to -196°C. Typical application is land based LNG tanks.

Specifications	
Classifications	SFA/AWS A5.11 : ENiCrMo-6 EN ISO 14172 : E Ni 6620 (NiCr14Mo7Fe)
Approvals	ABS : ENiCrMo-6 BV : ENiCrMo-6 ClassNK : KMWL92 DNV-GL : VL 1.5Ni up to VL 9Ni * KR : L 91 LR : 9Ni NAKS/HAKC : 2.5-4.0 mm RINA : N90

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+-
Alloy Type	Ni-based CrMoNb
Coating Type	Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	445 MPa (65 ksi)	727 MPa (105 ksi)	40 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	-196 °C (-321 °F)	91 J (67 ft-lb)

Typical Weld Metal Analysis %								
C	Mn	Si	Ni	Cr	Mo	Nb	W	Fe
0.05	3.0	0.3	69.4	12.9	6.2	1.3	1.6	5.0

Deposition Data					
Diameter	Current	Voltage	Deposition Efficiency (%)	Burn-off Time /Electrode	Deposition Rate @ 90% I max
2.5 x 350.0 mm (0.098 x 13.8 in.)	65-115 A	23 V	70 %	70 sec	1.1 kg/h (2.4 lbs/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	70-150 A	22 V	66 %	68 sec	1.5 kg/h (3.3 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	120-200 A	22 V	67 %	82 sec	1.9 kg/h (4.2 lbs/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	150-240 A	23 V	68 %	91 sec	2.8 kg/h (6.2 lbs/h)