

## OK NiCu 1

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.

### Specifications

<b>Classifications</b>	EN ISO 1071 : E C NiCu 1
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<b>Welding Current</b>	AC, DC+-
<b>Alloy Type</b>	Nickel-copper alloy
<b>Coating Type</b>	Basic Special

### Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cu	Fe
0.45	0.9	<0.2	63.5	32	3

### Deposition Data

Diameter	Current	Voltage	Deposition Efficiency (%)	Burn-off Time /Electrode	Deposition Rate @ 90% I max
2.5 x 300.0 mm ( 0.098 x 11.8 in. )	50-100 A	18 V	60 %	66 sec	0.6 kg/h ( 1.3 lbs/h )
3.2 x 350.0 mm ( 1/8 x 13.8 in. )	60-125 A	18 V	65 %	97 sec	0.8 kg/h ( 1.8 lbs/h )