

OK Ni-CI

OK Ni-CI is a nickel cored electrode for joining normal grades of cast iron, such as grey-, ductile- and malleable irons. It is also suitable for rectification and repair of these grades and for joining them to steel. Deposition is done on cold or slightly preheated cast iron. Weld metal is well machinable. Typical applications are repair of cast iron parts such as cracks in engine blocks, pump housings, gear boxes, frames as well as foundry defects.

Specifikace

Klasifikace	SFA/AWS A5.15 : ENi-CI EN ISO 1071 : E C Ni-CI 3
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Svaovací proud	AC, DC+-
Typ legování	Ni-base alloy
Typ obalu	Basic Special high graphite

Typického chemického složení svarového kovu v %

C	Mn	Si	Ni	Al	Cu	Fe
1.0	0.2	0.3	93.5	0.1	0.3	4.5

Údaje ukládání

Prmr	A	V	Účinnost (%)	as dohoení/elektroda	Výkon odtavení při 90 % max. hodnoty proudu
2.5 x 300.0 mm	55-110 A	21 V	71 %	46 sec	0.9 kg/h
3.2 x 350.0 mm	80-140 A	20 V	68 %	66 sec	1.2 kg/h
4.0 x 350.0 mm	100-190 A	19 V	70 %	71 sec	1.7 kg/h