

OK 94.35

OK 94.35 is a copper-nickel type welding electrode used for chemical process equipment, desalination plants and offshore application. It is suitable for joining and cladding of matching as well as dissimilar alloys.

Specifications

Classifications	SFA/AWS A5.6 : ECuNi EN ISO 17777 : E Cu 7158 (CuNi30Mn2FeTi)
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Welding Current	DC+
Alloy Type	Copper Nickel
Coating Type	Basic

Typical Weld Metal Analysis %

Mn	Ni	Cu	Fe
1.6	30	67	0.6

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	55-70 A	22 V	64 %	49 sec	3.9 kg/h
3.2 x 350.0 mm	70-120 A	23 V	66 %	50 sec	4.4 kg/h