

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

Tensile_Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	445 MPa	727 MPa	40 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-196 °C	91 J

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	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350.0 mm	65-115 A	23 V	70 %	70 sec	1.1 kg/h
3.2 x 350.0 mm	70-150 A	22 V	66 %	68 sec	1.5 kg/h
4.0 x 350.0 mm	120-200 A	22 V	67 %	82 sec	1.9 kg/h
5.0 x 350.0 mm	150-240 A	23 V	68 %	91 sec	2.8 kg/h