

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

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

Typical Weld Metal Analysis %

C	Mn	Ni	Cu	Fe
0.3	0.9	65	31	3

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	50-100 A	18 V	60 %	66 sec	0.6 kg/h
3.2 x 350.0 mm	60-125 A	18 V	65 %	97 sec	0.8 kg/h