

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.

Specifiche	
Classificazioni	SFA/AWS A5.15 : ENi-CI EN ISO 1071 : E C Ni-CI 3

Corrente di saldatura	AC, DC+-
Tipo di lega	Ni-base alloy
Tipo di rivestimento	Basic Special high graphite

analisi tipica del deposito						
C	Mn	Si	Ni	Al	Cu	Fe
1.0	0.2	0.3	93.5	0.1	0.3	4.5

Dati deposito					
Diametro	Amp	Volt	Efficienza (%)	Tempo di fusione per elettrodo al 90% I max	Tasso di deposito al 90% I max
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