

## 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

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

### Typical Weld Metal Analysis %

<b>Mn</b>	<b>Ni</b>	<b>Cu</b>	<b>Fe</b>
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