

## OK Ni-1

A stick electrode for joining commercially pure nickel in wrought and cast forms. Also for joining dissimilar metals such as nickel to steel, nickel to copper and copper to steel. The electrode can also be used for surfacing steel.

### Specifications

<b>Classifications</b>	SFA/AWS A5.11 : ENi-1 EN ISO 14172 : E Ni 2061 (NiTi3)
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<b>Welding Current</b>	DC+
<b>Alloy Type</b>	Nickel-base
<b>Coating Type</b>	Lime Basic

### Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	330 MPa	470 MPa	30 %

### Typical Weld Metal Analysis %

C	Mn	Si	Ni	Al	Ti	Fe
0.04	0.4	0.7	96	0.10	1.5	0.4

### Deposition Data

Diameter	Amps	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 300.0 mm	70-95 A	55 %	47 sec	0.8 kg/h
3.2 x 350.0 mm	90-135 A	55 %	56 sec	1.2 kg/h