

## OK NiCu-7

OK NiCu-7 is used for welding NiCu-alloys. It can also be used to connect a NiCu alloy to a mild- and low alloy steel. This can only be done after the mild or low alloy steel surface has been buttered using a pure nickel grade such as OK Ni-1. OK NiCu-7 can be used for cladding of mild and low alloy steel after a buffer layer of nickel has been deposited.

### Specifications

<b>Classifications</b>	SFA/AWS A5.11 : ENiCu-7 EN ISO 14172 : E Ni 4060 (NiCu30Mn3Ti)
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<b>Welding Current</b>	DC+
<b>Ferrite Content</b>	FN 0
<b>Alloy Type</b>	NiCu-alloy
<b>Coating Type</b>	Basic

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	410 MPa ( 59 ksi )	640 MPa ( 93 ksi )	40 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>AWS</b>		
As Welded	20 °C ( 68 °F )	100 J ( 74 ft-lb )
As Welded	-196 °C ( -321 °F )	80 J ( 59 ft-lb )

### Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cu	Ti	Fe
0.02	3.0	0.5	66	29	0.4	1.9

### Deposition Data

Diameter	Current	Voltage	Deposition Efficiency (%)	Burn-off Time /Electrode	Deposition Rate @ 90% I max
2.5 x 300.0 mm ( 0.098 x 11.8 in. )	50-70 A	22 V	63 %	45 sec	1.0 kg/h ( 2.2 lbs/h )
3.2 x 350.0 mm ( 1/8 x 13.8 in. )	70-120 A	26 V	63 %	52 sec	1.6 kg/h ( 3.5 lbs/h )
4.0 x 350.0 mm ( 5/32 x 13.8 in. )	120-140 A	28 V	63 %	54 sec	2.4 kg/h ( 5.3 lbs/h )