

# OK 94.35



Copper-nickel electrode used for chemical process equipment, desalination plants and offshore applications. It is suitable for the joining and cladding of matching and dissimilar alloys.

<b>Classifications:</b>	SFA/AWS A5.6:ECuNi
<b>Welding Current:</b>	DC+
<b>Alloy Type:</b>	Copper Nickel
<b>Coating Type:</b>	Basic

## Typical Tensile Properties

Condition	Tensile Strength	Elongation
<b>AWS</b>		
As welded	400 MPa	30 %

## Typical Weld Metal Analysis %

Mn	Ni	Cu	Fe
1.6	30	67	0.6

## Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 300 mm	55-70 A	22 V	0.64	93	49 s	3.9 kg/h
3.2 x 350 mm	70-120 A	23 V	0.66	48	50 s	4.4 kg/h