

# OK Autrod Ni-1

A continuous solid nickel based electrode alloyed with about 3% Ti for welding of high purity nickel (min 99.6%Ni), ordinary wrought nickel and nickel with reduced C content. The weld metal can be used in a wide range of applications where the construction is working with corrosive media.

<b>Classifications Wire Electrode:</b>	SFA/AWS A5.14:ERNi-1, EN ISO 18274:S Ni 2061 (NiTi3)
<b>Approvals:</b>	VdTÜV 12658 (MV), VdTÜV 12664 (FP)

Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type:</b>	Nickel (Ni + 2.5 % Ti)
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## Typical Wire Composition %

C	Mn	Si	Ni	Al	Cu	Fe	Ti
0.01	0.4	0.5	96	0.06	0.01	0.04	3.1

## Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	100-200 A	21-27 V	6-13 m/min	2,5-5,5 kg/h