

# OK Ni-1



OK Ni-1 is a stick electrode for joining commercial pure nickel in wrought and cast forms. It can also be used to join dissimilar metals such as nickel to steel, nickel to copper and copper to steel. Moreover, this electrode can be used for surfacing steel.

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

## Typical Tensile Properties

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	Fe	Ti
0.04	0.4	0.7	96	0.10	0.4	1.5

## Deposition Data

Diameter	Current	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	70-95 A	0.55	96	47 s	0.80 kg/h
3.2 x 350 mm	90-135 A	0.55	53	56 s	1.20 kg/h