OK NiCu-7

A nickel-copper electrode for welding NiCu alloys to themselves and to steels and for corrosion-resistant surfacing. The weld metal of OK NiCu-7 is crack resistant and ductile and meets rigorous requirements relating to corrosion resistance in sea water and in reducing and oxidising acids. OK NiCu-7 is used for welding corrosion-resistant monel alloys within the petroleum and ammonium sulphate industry and in power plants.

Classifications:	SFA/AWS A5.11:ENiCu-7, EN ISO 14172:E Ni 4060 (NiCu30Mn3Ti)

Welding Current:	DC+
Ferrite Content:	FN 0
Alloy Type:	NiCu-alloy
Coating Type:	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As welded	410 MPa	640 MPa	40 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As welded	20 °C	100 J
As welded	-196 °C	80 J

Typical Weld Metal Analysis %

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

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	50-70 A	22 V	0.63	83	45 s	1.0 kg/h
3.2 x 350 mm	70-120 A	26 V	0.63	42	52 s	1.6 kg/h
4.0 x 350 mm	120-140 A	28 V	0.63	28	54 s	2.4 kg/h