

## OK Ni-CI



OK Ni-CI is a nickel cored electrode for joining normal grades of cast iron, such as grey-, ductile- and malleable irons. It is also suitable for rectification and repair of these grades and for joining them to steel. Deposition is done on cold or slightly preheated cast iron. Weld metal is well machinable. Typical applications are repair of cast iron parts such as cracks in engine blocks, pump housings, gear boxes, frames as well as foundry defects.

<b>Klasifikácie</b>	SFA/AWS A5.15 : ENi-CI EN ISO 1071 : E C Ni-CI 3
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<b>Zvárací prúd</b>	AC, DC+-
<b>Typ zliatiny</b>	Ni-base alloy
<b>Typ obalu</b>	Basic Special high graphite

### Typical Weld Metal Analysis %

C	Mn	Si	Ni	Al	Cu	Fe
1.0	0.2	0.3	93.5	0.1	0.3	4.5

### Naváracie údaje

Priemer	Prúd, A	V	Počet elektrod/zvarový kov	Doba odhorievania elektrody	Účinnosť %	Deposition Rate @ 90% I max
2.5 x 300.0 mm	55-110 A	21 V	83	46 sec	71 %	0.9 kg/h
3.2 x 350.0 mm	80-140 A	20 V	45	66 sec	68 %	1.2 kg/h
4.0 x 350.0 mm	100-190 A	19 V	29	71 sec	70 %	1.7 kg/h