

OK NiCu 1

OK NiCu 1 is a nickel-copper electrode of the monel-alloy type for welding all types of cast iron with or without low preheat. The weld metal is easily machinable and produces a colour very similar to that of cast iron.

Classifications:	EN ISO 1071:E C NiCu 1
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Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties		
Condition	Tensile Strength	Elongation
As Welded	300-350 MPa (43.5-51 ksi)	15 %

Typical Weld Metal Analysis %					
C	Mn	Si	Ni	Cu	Fe
0.45	0.9	<0.2	63.5	32	3

Deposition Data			
Diameter	Current	Voltage	Efficiency (%)
2.5 mm (3/32 in.)	50-100 A	18 V	95 %
3.2 mm (1/8 in.)	60-125 A	18 V	95 %
4 mm (5/32 in.)	90-140 A	18 V	95 %