

OK NiCu-7

OK NiCu-7 is used for welding NiCu-alloys. It can also be used to connect a NiCu alloy to a mild- and low alloy steel. This can only be done after the mild or low alloy steel surface has been buttered using a pure nickel grade such as OK Ni-1. OK NiCu-7 can be used for cladding of mild and low alloy steel after a buffer layer of nickel has been deposited.

Specifications

Classifications	SFA/AWS A5.11 : ENiCu-7 EN ISO 14172 : E Ni 4060 (NiCu30Mn3Ti)
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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	Ti	Fe
0.02	3.0	0.5	66	29	0.4	1.9

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	50-70 A	22 V	63 %	45 sec	1.0 kg/h
3.2 x 350.0 mm	70-120 A	26 V	63 %	52 sec	1.6 kg/h
4.0 x 350.0 mm	120-140 A	28 V	63 %	54 sec	2.4 kg/h