

OK NiCu 1



OK NiCu 1 is a nickel-copper cored electrode of monel type for welding normal grades of cast iron such as gray-, ductile- and malleable irons. Deposition is done on cold or slightly preheated material.
The weld metal is well machinable and provides a good colour match to that of cast iron.

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| Классификации | EN ISO 1071 : E C NiCu 1 |
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| Тип сплава | Nickel-copper alloy |
| Тип покрытия | Basic Special |

Хим. состав наплавленного металла

| C | Mn | Si | Ni | Cu | Fe |
|-----|-----|----|----|----|----|
| 0.3 | 0.9 | | 65 | 31 | 3 |

Данные наплавки

| Диаметр | Ток | В | Кол-во электродов/кг наплавл. Металла | Fusion time per electrode at 90% I max | КПД, % | Производительность наплавки при токе 90% от максимального |
|----------------|----------|------|---------------------------------------|--|--------|---|
| 2.5 x 300.0 mm | 50-100 A | 18 V | 96.0 | 66 sec | 60 % | 0.6 kg/h |
| 3.2 x 350.0 mm | 60-125 A | 18 V | 49.0 | 97 sec | 65 % | 0.8 kg/h |
| 4.0 x 350.0 mm | 90-140 A | 18 V | 32.0 | 130 sec | 65 % | 0.9 kg/h |