

## 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>Классификации</b>	AWS A5.15 : ENi-CI EN ISO 1071 : E C Ni-CI 3
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<b>Сварочный ток</b>	AC, DC+-
<b>Тип сплава</b>	Ni-base alloy
<b>Тип покрытия</b>	Basic Special high graphite

### Хим. состав наплавленного металла

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

### 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	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