



OK 92.18

SMAW

A nickel-cored electrode for welding normal grades of cast iron. The weld metal is soft and easily machinable. Deposition is performed on cold or slightly preheated material. The electrode is suitable for joining cast iron for the rectification of casting and the repair of broken parts.

Welding Current

AC, DC+ OCV 50 V



PACKING/ORDERING INFORMATION				
Part Number	Dia (mm)	Inner Carton (kg)	Carton Weight (kg)	Pallet Weight (kg)
VacPac				
92182520K0	2.5	0.7	6.3	485.1
92183230K0	3.2	0.8	7.2	482.4
92184030G0	4.0	2.3	13.8	924.6

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
<u>SFA/AWS A5.15</u> Eni-CI <u>EN ISO 1071</u> E C Ni-CI 3	Sepros UNA 409820	C 0.9 Si <0.9 Mn <0.6 Ni >92.0 Fe 3.5	<u>Yield Stress, Mpa</u> 300 <u>Hardness</u> 150 HB

WELDING PARAMETERS							
Diameter (mm)	Length (mm)	Welding Current, A	Arc Voltage, V	N. Kg Weld Metal/(kg) Electrodes	B. No. Of Electrodes/(kg) Weld Metal	H. Kg Weld Metal/(hour) Arc Time	T. Burn-off time, (secs)/ Electrode
2.5	300	55-110	20	0.71	83.3	0.9	46
3.2	350	80-140	20	0.68	44.8	1.2	66
4.0	350	100-190	20	0.70	29.4	1.7	71

