

OK 92.45

Type Basic

SMAW
ENiCrMo-3

Description

OK 92.45 is a NiCrMoNb-based electrode for welding nickel alloys of the same or similar type, like Inconel 625, and for welding 5Ni and 9Ni steel. OK 92.45 is also suitable for welding UNS S31254 steel.

Welding current

DC+



Classifications

| | |
|---------------|----------------------------|
| SFA/AWS A5.11 | ENiCrMo-3 |
| EN ISO 14172 | E Ni 6625 (NiCr22Mo9Nb) |

Typical all weld metal composition, %

| C | Si | Mn | Cr | Ni | Mo | Nb | Cu | Al | Fe |
|------|-----|-----|------|----|-----|-----|------|------|-----|
| 0.03 | 0.4 | 0.2 | 21.7 | 63 | 9.3 | 3.3 | <0.3 | <0.4 | 2.0 |

Typical mech. properties all weld metal

| | |
|-----------------------|-----|
| Yield stress, MPa | 500 |
| Tensile strength, MPa | 780 |
| Elongation A5, % | |

Charpy V

| Test temps, °C | Impact values, J |
|----------------|------------------|
| +20 | 70 |
| -196 | 50 |

Approvals

| | |
|-------|----------|
| UDT | DIN 1736 |
| VdTÜV | 06833 |

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, s/electrode |
|--------------|------------|--------------------|----------------|-----------------------------------|---------------------------------------|-----------------------------------|----------------------------------|
| 2.5 | 300 | 50-80 | 23 | 0.6 | 100 | 0.9 | 40 |
| 3.2 | 350 | 70-110 | 25 | 0.6 | 49 | 1.4 | 52 |
| 4.0 | 350 | 100-140 | 27 | 0.6 | 33 | 1.9 | 57 |
| 5.0 | 350 | 120-170 | 24 | 0.6 | 21 | 2.1 | 72 |