

OK 92.55

Type Basic

SMAW
ENiCrMo-6

Description

OK 92.55 is an all-positional, basic coated electrode which deposits a NiCr-based alloy with additions of Mo, W and Nb. The electrode is specifically designed for welding 9%Ni steels for cryogenic applications down to -196°C.

Welding current

AC, DC+ - OCV 55 V



Classifications

SFA/AWS A5.11 ENiCrMo-6
EN ISO 14172 E Ni 6620
(NiCr14Mo7Fe)

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	W	Nb	Cu	Fe
0.05	0.3	3.0	13.0	69	6.2	1.6	1.3	<0.3	5.0

Typical mech. properties all weld metal

Yield stress, MPa >430
Tensile strength, MPa >690
Elongation A4, % >35

Charpy V

Test temps, °C Impact values, J
-196 >70

Approvals

ABS ENiCrMo-6

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	350	65-115	22	0.66	34	1.5	68
3.2	350	70-150	22	0.66	34	1.5	68
4.0	350	120-200	22	0.67	23	1.9	82
5.0	350	150-240	23	0.68	14	2.8	91