

# OK 94.35

Type Basic

SMAW

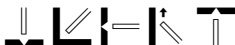
ECuNi

## Description

Copper-nickel electrode used for chemical process equipment, desalination plants and offshore applications. It is suitable for the joining and cladding of matching and dissimilar alloys.

## Welding current

DC+



## Classifications

SFA/AWS A5.6

ECuNi

DIN 1733

EL-CuNi30Mn

## Typical all weld metal composition, %

C	Si	Mn	Ni	Ti	Fe	Cu
<0.05	<0.5	1.5	30.5	<0.5	0.6	bal.

## Typical mech. properties all weld metal

Tensile strength, MPa	400
Elongation, A4 (%)	30

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	55-70	23
3.2	350	70-120	25