

OK 92.55



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.

Classifications:	SFA/AWS A5.11:ENiCrMo-6, EN ISO 14172:E Ni 6620 (NiCr14Mo7Fe)
Approvals:	CE EN 13479, ABS ENiCrMo-6, BV N50 and 9Ni*, DNV For welding NV 1.5Ni to NV 9Ni, GL NiCr14Mo7Fe, incl X8Ni9*, LR 9Ni

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	AC, DC+-
Ferrite Content:	FN 0
Alloy Type:	Ni-based CrMoNb
Coating Type:	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	445 MPa	727 MPa	40 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	-196 °C	91 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Fe	Nb	W
0.05	3.0	0.3	69.4	12.9	6.2	5.0	1.3	1.6

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 350 mm	65-115 A	23 V	0.70	55	70 s	1.1 kg/h
3.2 x 350 mm	70-150 A	22 V	0.66	34	68 s	1.5 kg/h
4.0 x 350 mm	120-200 A	22 V	0.67	23	82 s	1.9 kg/h
5.0 x 350 mm	150-240 A	23 V	0.68	14	91 s	2.8 kg/h