

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	BV N50 and Equivalent to SFA/AWS A5.11 ENiCrMo-6 ABS ENiCrMo-6 CE EN 13479 ClassNK KMWL92 DNV-GL VL 1.5Ni up to VL 9Ni KR L 91 LR 9Ni NAKS/HAKC 2.5-4.0 mm RINA N90

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

Welding Current	AC, DC+-
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	Nb	Fe	W
0.05	3.0	0.3	69.4	12.9	6.2	1.3	5.0	1.6

Current Range

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 350.0 mm	65-115 A	23 V	55	70 sec	70 %	1.1 kg/h
3.2 x 350.0 mm	70-150 A	22 V	34	68 sec	66 %	1.5 kg/h
4.0 x 350.0 mm	120-200 A	22 V	23	82 sec	67 %	1.9 kg/h
5.0 x 350.0 mm	150-240 A	23 V	14	91 sec	68 %	2.8 kg/h

*See certificates for details.