

E NiCu30Mn

CATEGORY SMAW Stick Electrodes

TYPE Nickel based SMAW electrode alloyed with Copper.

APPLICATIONS Shipbuilding, seawater evaporation plants, tubes, pump building, offshore etc. NiCu30Mn is suitable for dissimilar welding between Nickel 200-201, stainless steel, carbon steel, Inconel and Incoloy alloys, Nickel Copper and Copper nickel alloys.

PROPERTIES This Nickel - Copper weld metal has properties similar to "Monel 400". It has good strength and resists corrosion in many media, including sea water, salts and reducing acids. The weld metal is not age hardenable and when used to join Monel K-500 it has lower strength than the base metal.

CLASSIFICATION

AWS	A 5.11: E NiCu-7
EN ISO	14172: E Ni 4060
DIN: W.Nr.	2.4366
DIN	1736: EL-NiCu30Mn

SUITABLE FOR 2.4360, 2.4375, NiCu30Fe, NiCu30Al, Monel 400, R405, alloy K500 and dissimilar welding between these alloys.

WELDING POSITIONS:



C	Mn	Si	Fe	Ni+Co	Cu	Al	Ti
<0.15	<4.0	<1.0	<2.5	62.0-68.0	Rem	<0.75	<1.0

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW		>483	>30				

AW = as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.4	305	55-75			
3.2	356	75-110			
4.0	356	110-150			
4.8	356	150-190			

REDRYING TEMPERATURE 250-300°C/1hr