



SUPERMONEL

NON FERROUS (Ni Alloys)



Monel Electrode for joining and surfacing of nickel copper alloys

CLASSIFICATION : ISO 14172

AWS A/SFA 5.11

E Ni 4060 (NiCu30Mn3Ti)

E NiCu-7

KEY FEATURES :

- Monel electrode
- Low iron in the deposit exhibit maximum corrosion resistance
- Medium penetration weld
- Easily machinable deposit in as welded and stress relieved condition
- Passes 180° bend test on monel alloy 400 plate

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Welding monel to itself, to stainless steels or carbon steels
- Overlaying on steel to obtain a corrosion resistant surface
- Welding of ASTM B127/163/164/165
- Refineries, Off shore, Foundries, Chemical and Fertilizer plants
- Heat exchanger, Pressure vessel and Column manufacturing units
- Food, Pumps & Valves manufacturing units

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Ni	Fe	Ti
Typical	0.05	2.0	0.4	65.0	1.5	0.7
Specification	0.15 max	4.0 max	1.5 max	62 to 69	2.5 max	0.30-1.0
	S	P	Cu	Ai	Ti	Other
Typical	0.01	0.01	Rem.	-	-	
Specification	0.015 max	0.02 max	Rem.	0.75 max	1.0 max	0.50 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Typical	As Welded	535	34
Specification		480 min	30 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 350	45 - 70	1	10	10
3.15 x 350	80 - 100	1	10	10
4.0 x 350	90 - 130	1	10	10

EQUIVALENT : GMAW wire: : Automig NiCu-7

GTAW filler: Tigfil NiCu-7