

# SUPERMONEL

AWS A/SFA 5.11 ENiCu-7

NON FERROUS (Ni Alloys)

## CLASSIFICATION:

ISO 14172  
E Ni 4060 (NiCu30Mn3Ti)

## 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

**APPROVALS:** CE

## 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



## TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni	Al	Ti
0.02	3.1	1.0	1.0	65	0.04	0.4

## MECHANICAL PROPERTIES OF ALL WELD METAL:

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

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 2.5 x 350 3.15 x 350 4.0 x 350	<b>Amperage, A</b> 45 - 70 80 - 100 90 - 130	 <b>DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
----------------------------------------------------------	-------------------------------------------------------	------------------------------------------------------------------------------------------------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------------------------------

Available in Ivory packing of 10 kg box containing 10 cartons of 1 kg each.