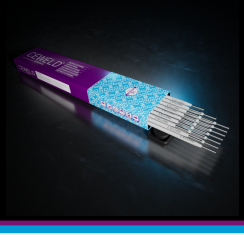


CEWELD E NiCu30Mn

certilas® THE FILLER METAL SPECIALIST

TYPE

Nickel based SMAW electrode alloyed with Copper for Monel 400 (500). (Type E NiCu-7, E Ni4060)

APPLICATIONS

CEWELD® E NiCu30Mn is suitable for dissimilar welding between Nickel 200-201, stainless steel, carbon steel, Inconel and Incoloy Alloys, Nickel Copper and Copper nickel alloys.
Areas of application: Offshore and shipbuilding, heat exchangers, pipelines, desalination plants, chemicals, petrochemicals and energy technology.

PROPERTIES

CEWELD® E NiCu30Mn has properties similar to "Monel 400". Have 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 then the base metal.
Cold-resistant down to -196°C.

CLASSIFICATION

AWS	A 5.11: E NiCu-7
EN ISO	14172: E Ni 4060 (NiCu30Mn3Ti)
W.Nr.	2.4366
F-nr	42
FM	6

SUITABLE FOR

E Ni 4060 (NiCu30Mn3Ti)
2.4360, 2.4361, 2.4365, 2.4375, (2.0872, 2.0882, 2.0890)
NiCu30Fe, NiCu30Al, G-NiCu 30 Nb, LC-NiCu 30 Fe,
ASTM B127, B163, B164, B165
UNS N04400
Monel 400, Monel R405, Monel K-500
Alloy K500 and dissimilar welding between these Alloys.

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Ni	Ti	Fe	Cu
0.1	1	3	68	0.5	1.5	30

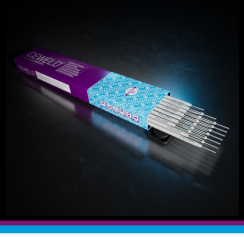
MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	330	640	36	90	50	HRc

REDRYING

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCu30Mn

E NICU30MN 2,4 X 305MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419194

E NICU30MN 3,2 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419200

E NICU30MN 4,0 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419217