



CEWELD E NiCu30Mn

TYPE	Nickel based SMAW electrode alloyed with Copper.						
APPLICATIONS	Shipbuilding, seawater evaporation plants, tubes, pump building, offshore etc. 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.						
PROPRIÉTÉS	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 then the base metal.						
CLASSIFICATION	AWS	A 5.11: E NiCu-7					
	EN ISO	14172: E Ni 4060 (NiCu30Mn3Ti)					
	W.Nr.	2.4366					
	F-nr	42					
	FM	6					
CONVIENT POUR	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.						
AGRÉMENTS							
POSITIONS DE SOUDAGE							
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	Ni	Ti	Fe	Cu
	0.1	1	3	68	0.5	1.5	30
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					RT	-196°C	
	As Welded	330	640	36	90	50	HRc
ETUVAGE	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