



## Monel Electrode for joining and surfacing of nickel copper alloys

CLASSIFICATION : EN ISO 14172      AWS A/SFA 5.11  
E Ni 4060      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 and Valves manufacturing units

REDRYING CONDITION : 300°C for 1 hr. (Also available in vacuum packed condition)

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

|               | C        | Mn      | Si        | Ni        | Fe      | Ti       | S         | P        | Cu   |
|---------------|----------|---------|-----------|-----------|---------|----------|-----------|----------|------|
| Typical       | 0.05     | 2.0     | 0.4       | 65.0      | 1.5     | 0.7      | 0.01      | 0.01     | Bal. |
| Specification | 0.08 max | 1.0-3.0 | 0.20-0.80 | 62.0-68.0 | 1.0-2.5 | 0.30-1.0 | 0.015 max | 0.02 max | Bal. |

### MECHANICAL PROPERTIES OF ALL WELD METAL :

|               | Condition | UTS, MPa | EL%   |
|---------------|-----------|----------|-------|
| Typical       | As Welded | 535      | 34    |
| Specification |           | 490-590  | 30-40 |

### PARAMETERS - PACKING DATA :

| Ø x L, mm  | Amperage, A | Wt./Carton, Kg | Cartons/Box | Net wt./Box, Kg |
|------------|-------------|----------------|-------------|-----------------|
| 2.5 x 300  | 40-80       | 1              | 10          | 10              |
| 3.15 x 300 | 80-110      | 1              | 10          | 10              |
| 4.0 x 300  | 110-140     | 1              | 10          | 10              |

EQUIVALENT : GMAW wire : Automig NiCu-7

GTAW filler: Tigfil NiCu-7