



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.

PROPERTIES 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 than 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

SUITABLE FOR 2.4360, 2.4375, NiCu30Fe, NiCu30Al, Monel 400, R405, 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)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	330	640	36	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