



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 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

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