




# 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 then the base metal.						
CLASSIFICATION	AWS	A 5.11: E NiCu-7					
	EN ISO	14172: E Ni 4060 (NiCu30Mn3Ti)					
	F-nr	42					
	FM	6					
	W.Nr.	2.4366					
SUITABLE FOR	2.4360, 2.4375, NiCu30Fe, NiCu30Al, Monel 400, R405, Alloy K500 and dissimilar welding between these Alloys.						
APPROVALS	No Approvals Found						
WELDING POSITIONS	<div> PA</div> <div> PB</div> <div> PC</div>						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Ni	Ti	Fe	Cu
	0.1	1	3	68	0.5	1.5	30
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A5 (%)			
	As Welded /1h	330	640	36			
REDRYING TEMPERATURE	300°C / 2 hr						
GAS ACCORDING EN 14175							



# CEWELD E NiCu30Mn

E NICU30MN 2,4 X 305MM

Type	KG/unit	EANCode
Can	2,27	8720663419194

E NICU30MN 3,2 X 356MM

Type	KG/unit	EANCode
Can	2,27	8720663419200

E NICU30MN 4,0 X 356MM

Type	KG/unit	EANCode
Can	2,27	8720663419217