

Applications

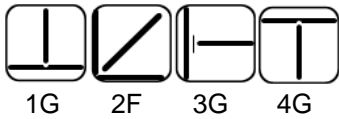
It is used for welding the clab side of joints in steel clad with a Nickel – Copper alloy and for surfacing steel with Nickel – Copper alloy weld metal to obtain a corrosion resistant surface. It is also used for fabrication and welding for the Nickel – Copper base material like ASTM – B127, B 163, B 164, and B 165 all of which have UNS No. 4400.

Characteristics on Usage

It is a medium coated basic type Monel electrode, it gives stable arc with medium penetration and easily removable slag. The weld deposit contain Ni – Cu alloys elements, and gives Radiographic quality.

Notes On Usage

- 1) Chip off base metal completely at the repairing part .
- 2) There is possibility that cracks spreads or makes holes at both ends of repairing part .
- 3) Keep the weld metal length less than 50 mm (2 inch) to disperse welding heat- adopt back stepping stone or symmetry method by turns.
- 4) The preheat temprature vary in accordance with te size ,king and shape of the base metal 150°C is appropriate in general .

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Ni %	Cu %	Fe%
0.15 Max	4.00 Max	1.50 Max	0.015 Max	0.020 Max	62 - 69	Balance	2.50 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION
480 Min	30 % Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 X 350	2	10	DC (+)	60 - 80
3.15 X 350	2	10		80 - 110
4.00 X 350	2	10		110 - 140
5.00 X 350	2	10		140 – 190

Packing

Vaccum packing