



# 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**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Ni	Ti	Fe	Cu
0.1	1	3	68	0.5	1.5	30

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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