

E CuNi30Mn

CATEGORY	SMAW Stick Electrodes
TYPE	Copper-Nickel based stick electrode (SMAW)

APPLICATIONS Wrought or cast copper nickel alloys, marine applications, disalination exuipment.

PROPERTIES Excellent corosion resistance in seawater and against fouling. Suitable for dissimilar welding of Monel alloy 450 to Nickel 200 and or other Copper -Nickel alloys. Small diameters can be used in all positions.

CLASSIFICATION	AWS	A 5.6: E CuNi (UNS W 60715)
	EN ISO	E Cu 7158 (CuNi30)
	DIN: W.Nr.	2.0838
	DIN	1733: S CuNi30Mn

SUITABLE FOR (Monel 67): Wrought and cast alloys of 70-30, 80-20 and 90-10 copper nickel alloys, Monel alloy 450, Nickel 200, CuNi10Fe, CuNi20Fe (2.0878), CuNi30Fe (2.0882).

WELDING POSITIONS:

FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Ni+Co	Fe	Cu	Ti	P	S
<0.05	1.0-2.5	<0.5	>29	0.4-0.75	Rem	<0.5	<0.020	<0.015

MECHANICAL PROPERTIES

Heat Treatment	Tensile strenght		A5 4D (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
	psi	MPa		-20°C	-40°C	-60°C	
AW	>50,000	>345	>30				

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) (DC+)	kg / can	kg / 6 pack	kg / 1000
2.4	305	60-85			
3.2	356	70-120			
4.0	356	100-145			
4.8	356	130-190			