

RATNA Ni Cu

Medium heavy coated low hydrogen basic coated Monel Electrode.

CLASSIFICATION : AWS/SFA-5.11: E NiCu 7

APPROVAL :

CHARACTERISTICS : A medium heavy coated, low hydrogen basic coated, monel electrode. Electrode has extensive corrosion resistance properties due to minimum iron content in the weld deposit. The joints are radiographically sound

APPLICATION :

- 1) Suitable to weld monel metals to itself.
- 2) Monel to carbon steel or stainless steel.
- 3) Welding on clad side or monel clad steel.
- 4) Seawater corrosion resistance applications, petrochemical, daily beverage industries, chemical industries etc.

RE-DRY CONDITION : Re-Dry the electrode at 250°C for 1 hour before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Al	Ti	Fe	Cu
0.15 max.	4.00 Max	1.50 max	62.00-69.00	Al 0.75 Max.	2.00 Max	2.50 Max	Bal.

WELD METAL HARDNESS:

UTS N/mm ²	EL % (l=4d)
480 Min.	30 Min

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+) Amps	Wt. of /pkt.	Wt. of Case
2.50/ 2.40 X 350	3/ 32" X 14"	80-100	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	100-130	2	20
4.00 X 350	5/ 32" X 14"	140-180	2	20
5.00 X 350	3/ 16" X 14"	170-200	2	20

Customer packing on request.