

ROYAL – MONEL (E Ni Cu – 7)

AWS : A / SFA 5.11, E Ni Cu - 7 EN ISO 1472 A E Ni 4060

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.

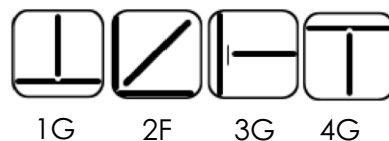
Characteristics on Usage

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.

Packing

Vaccum packing

Welding Positions



Notes On Usage

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

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 (+)	40 - 60
3.15 x 350	2	10		60 - 80
4.00 x 350	2	10		100 – 140
5.00 x 350	2	10		140 – 190