



# CEWELD E NiCu30Mn

**TYPE** Nickel based SMAW electrode alloyed with Copper for Monel 400 (500). (Type E NiCu-7, E Ni4060)

**APPLICATIONS** **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.

**Areas of application:** Offshore and shipbuilding, heat exchangers, pipelines, desalination plants, chemicals, petrochemicals and energy technology.

**PROPERTIES** **CEWELD® E NiCu30Mn** has properties similar to "Monel 400". Have 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 then the base metal. Cold-resistant down to -196°C.

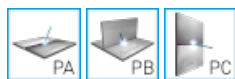
**CLASSIFICATION**

|        |                                |
|--------|--------------------------------|
| AWS    | A 5.11: E NiCu-7               |
| EN ISO | 14172: E Ni 4060 (NiCu30Mn3Ti) |
| W.Nr.  | 2.4366                         |
| F-nr   | 42                             |
| FM     | 6                              |

**SUITABLE FOR** **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.

## APPROVALS

## WELDING POSITIONS



## TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

## MECHANICAL PROPERTIES

| 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      |

**REDRYING** 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 |