

MMA Electrodes Nickel and Copper alloys

Low-hydrogen MMA electrode suitable for all positional welding. Suitable for welding pure nickel and nickel alloys and for joining these materials with unalloyed and low alloyed steels, additional applications include buffer layers on carbon steels or stainless steels before joining to nickel or copper alloys.
Efficiency 100%.

Classification

AWS	A5.11: E Ni-1
EN ISO	14172: E Ni 2061

Approvals

Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.01	0.30	0.80	0.005	0.005	-	Rem	-	-	0.40	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -196°C	Hardness
As Welded	≥ 200	≥ 410	≥ 20	≥ 100	-

Materials

2.4066; 2.4068; 2.4061; 2.4060

UNS N02200; UNS N02201; UNS N02205

Storage and redrying

Keep dry and avoid condensation.

Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

DC+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
3,2	350	65-100	33,5	20,1
4,0	350	85-120	50,4	30,2