

MMA Electrodes Nickel and Copper alloys

Basic coated MMA electrode depositing 65 % Ni, 16 % Cr and 8 % Fe for the welding of:

Heat and corrosion resisting nickel alloys, such as NiCr15Fe (2.4816) and LC-NiCr15Fe (2.4817), to itself or to unalloyed, low-or high-alloy steels, tough at sub zero temperatures down to $-196\text{ }^{\circ}\text{C}$, and creep resisting up to $800\text{ }^{\circ}\text{C}$. Ferritic to austenitic steels subjected to operating temperatures of $+300\text{ }^{\circ}\text{C}$.

Due to the high toughness properties and resistance to cracking, Supranel SR is suitable for joining difficult-to-weld steels and maintenance welding of critical components.

Classification

AWS	A5.1: ENiCrFe-2
EN ISO	14172: E Ni 6062 (NiCr15Fe8Nb)

Approvals

Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
≤ 0.08	2	0.30	≤ 0.020	≤ 0.015	16	Rem	-	1.80	8.50	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm^2	Tensile Strength N/mm^2	Elongation A5 (%)	Impact Energy ISO - V (J) - $196\text{ }^{\circ}\text{C}$	Hardness
As Welded	≥ 360	≥ 550	≥ 35	≥ 60	-

Materials

2.4816; 1.4876; 1.4958

UNS N06600; UNS N08800; UNS N08810

Storage and redrying

Keep dry and avoid condensation.

Re-dry at $300\text{-}350\text{ }^{\circ}\text{C}$ 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)
2,5	300	50-70	17,3	10,4
3,2	350	70-95	33,9	20,3
4,0	350	90-130	48,6	29,1