

## MMA Electrodes Nickel and Copper alloys

Supranel 600 is suitable for welding 9% Ni steels operating at temperatures down to -196°C. Also suitable for welding dissimilar, refractory and difficult-to-weld steels.  
Efficiency 100%.

Classification	
AWS	A5.11: E NiCrFe-3
EN ISO	14172: E Ni 6182

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.04	7.50	0.60	≤ 0.020	≤ 0.015	16	Rem	-	1.80	7.50	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -196°C	Hardness
As Welded	≥ 360	≥ 550	≥ 30	≥ 60	-

### Materials

2.4816; 1.4876; 1.4958

UNS N06600; UNS N08800; UNS N08810

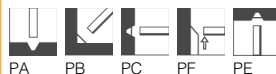
### Storage and redrying

Keep dry and avoid condensation.

Re-dry at 300-350 °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)
2,5	300	50-70	18,5	11,1
3,2	350	75-95	36,0	21,6
4,0	350	100-130	52,9	32,1
5,0	350	140-170	80,0	48,0