SUPRANEL NiCu7

OERLIKON

MMA Electrodes
Nickel and Copper alloys

Supranel NiCu7 is suitable for the welding or facing of alloys having the same chemical composition or for cladding. Excellent mechanical properties and resistant to chemical corrosion. A typical application is in desalination plants for the welding of Monel type alloy.
Efficiency 100%.

Classification	
AWS	A5.11: E NiCu-7
EN ISO	14172: E Ni 4060

Approvals	Grades
MMI	

see Appendix, Classification Society Approvals, for details pag. 521

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.015	3.40	0.40	≤ 0.020	≤ 0.015	-	Rem	-	-	0.80	-	29

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm^2	Tensile Strength N/mm^2	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	≥ 200	≥ 480	≥ 30	-	-

Materials

2.4360 (NiCu30Fe); 2.4375 (NiCu30Al)
UNS N04400; UNS N 05500

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+; AC

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	50-70	16,3	9,8
3,2	350	75-100	31,6	19,0
4,0	350	90-130	48,0	28,8