

Superfonte BM deposits a monel type alloy composition of relatively high strength and ductility, with a low fusion point. Particularly suitable for the repair of casting defects and damaged castings. Efficiency 100%.

Classification

AWS A 5.15: E NiCu B

Approvals

Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.40	0.80	0.05	≤ 0.025	≤ 0.025	-	Rem	-	-	5	-	30

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

Materials

GJS-350 to GJS-700;GJMW -350-4 to GJMW-360-12;GJMB-300 to GJMB-700

Storage and redrying

Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 80 °C for 1 hour, once only.

Current condition and welding position

DC+; AC



PA PB PC

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	45-80	16,0	9,7
3,2	350	90-120	31,2	18,9
4,0	350	120-140	45,8	27,9