

SUPERMONEL

CLASSIFICATIONS

AWS A/SFA 5.11 ENiCu-7

IDENTIFICATION: Name Printed

CHARACTERISTICS

A Monel electrode giving a smooth arc, medium penetration. The slag is a little difficult to remove in a groove, which is a typical characteristic of this type of electrode. The welds are of radiographic quality. A special feature of this electrode is low iron content in the weld deposit, which ensures maximum corrosion resistance. It passes 180° bend test on butt joints in monel Alloy 400 plate. It is easily machinable in the as-deposited condition and after stress-relieving.

TYPICAL APPLICATIONS

For welding Monel to itself, to stainless steel or carbon steels and for overlaying on steel to obtain a corrosion resistant surface. Welding of ASTM B127/163/164/165 having UNS no. N04400. Industry Sectors: Refineries, Off-shore, Fertilizers, Foundries, Heat Exchanger/ Pressure Vessel/ Columns manufacturing units, Food, Pumps and valves manufacturing units, chemical plants etc.

CURRENT CONDITIONS: DC (+)

4.0	3.2	2.5
110-140	80-110	40-80

WELDING POSITIONS

F & H Fillet

REDRYING CONDITIONS

300°C for 1 hour (Optionally also available in vacuum-packed condition.)

WELD METAL CHEMISTRY, (%)

C - 0.08 max.	Ni - 62.0 - 68.0	Cu Balance
Mn - 1.0 - 3.0	Ti - 0.30 - 1.0	P - 0.02 max.
Si - 0.20 - 0.80	Fe - 1.0 - 2.5	S - 0.015 max.

MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS	% Elong.
As-welded	MPa 490-590	(L=4xd) 30-40

PACKING DATA

Dia., mm	4.0	3.2	2.5
Length, mm	300	300	300
Wt. per carton, kg	1	1	1
Cartons / box	10	10	10
Net wt per box, kg	10	10	10



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ADOR WELDING LIMITED

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