

SUPRANEL NiCu7 is a basic-coated MMA electrode for joining similar 70Ni - 30Cu, Monel alloys. Suitable for joining and for surfacing of unalloyed or low-alloy steels and cast iron. The weld metal has a high corrosion resistance in saline solution and seawater. Typical applications include the chemical industry and seawater desalination plants.

Classification

EN ISO	14172: E Ni 4060 (NiCu30Mn3Ti)
AWS	A5.11: E NiCu-7

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Cu	Fe	Ti
0.015	3.5	0.4	≤ 0.02	≤ 0.015	Rem	29	0.8	0.5

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)
As Welded	≥ 200	≥ 480	≥ 30

Materials

2.4360 (NiCu30Fe); 2.4375 (NiCu30Al)

UNS N04400; UNS N 05500

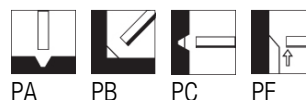
Storage

Keep dry and avoid condensation.

Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	VPMD	
				PC	Code
2.5	300	50-70	17.8	110	●
3.2	350	75-100	31.6	65	●
4.0	350	90-130	48.0	45	●