

MONEL® Welding Electrode 187

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MONEL Welding Electrode 187 is used for shielded-metal-arc welding of wrought or cast 70/30, 80/20, and 90/10 copper-nickel alloys. Like the base metals with which it is used, the weld metal resists fouling and corrosion in sea water and is useful for many marine and desalination applications. Dissimilar joints welded with the electrode include those between copper-nickel alloys and MONEL alloy 400 or Nickel 200.

The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive.

Specifications

AWS A5.6 ECuNi (UNS W60715)

ASME II, Part C, SFA-5.6, ECuNi (UNS W60715)

ASME IX, F-No.34

*DIN 1733 S CuNi30Mn (2.0838)

*(EN) ISO ECu 7158 (CuNi30)

*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), MIL and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

VdTUV 4530.01

Other approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition

Ni+Co.....	29.0 min.	Si	0.50 max.
C	0.05 max.	Cu	Remainder
Mn	1.0-2.50	Ti.....	0.50 max.
Fe	0.40-0.75	P	0.020 max
S	0.015 max.	Others	0.50 max.

Minimum Mechanical Properties

Tensile Strength, psi	50,000
MPa	345
Elongation, (4d) %	30

Available Product Forms – Supplied in 10lbs (4.54kg) hermetically sealed containers

Diameter	mm in	2.4 3/32	3.2 1/8	4.0 5/32	4.8 3/16
Length	mm in	305 12	356 14	356 14	356 14
Current (DC+)	A	60-85	70-120	100-145	130-190