

LH 511

ELECTRODE FOR WELDING MONEL
(NICKEL-COPPER) ALLOYS

PROPERTIES

The weld metal is free from porosity & resistant to many chemicals. Suitable for applications with working temperatures from -196 to +450°C. It is advisable to provide protection for the seam underside when welding thin sheets, in order to avoid porosity.

PROCEDURE

Clean the area to be welded. Preheat sections above 25 mm to 100°C. Adopt short arc, stringer bead technique, chip the slag completely. Allow the job to cool slowly to room temperature.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-80
	3.2x350	90-120
	4.0x350	110-140

TYPICAL APPLICATIONS

Used for joining & cladding Monel, alloy steels, dissimilar steels. Suitable for welding following grades: Wnr. 2.4360, 2.4374, 2.4400, valves, pumps, impellers, etc.



SPECIFICATIONS

Alloy Basis Ni, Cu, Ti, Fe, Mn
AWS / A 5.11 E Ni Cu-7



TECHNICAL DATA

UTS 48-55 kgf/mm²
Elongation 30-35%