

**Applications**

It is used for welding of wrought or cast 70/30 , 80/20 and 90/10 Copper - Nickel Alloys. Also used for welding of clad side of Copper nickel clad steel, desalination plant, evaporators etc. in salt and sea water processing system .

**Characteristics on Usage**

It is a copper nickel type welding electrodes deposits 90 % copper 10 % Nickel Weld metal, which is highly resistance to corrosion, erosion or cavitations in salt and brackish water. The preheating is not normally require, Maximum interpass temperature 150° C and no PWHT

**Welding Positions**

1G 2F 3G 4G

**Chemical Composition Of Weld Metal**

Mn%	Si%	P%	Ni %	Cu %	Fe%	Ti %
1.00 – 2.50	0.50 max	0.020 Max	10.0	Bal.	0.40 – 0.75	0.50 Max

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
350 Min	20 % Min

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC/DC (+)	50 - 80
3.15 x 350	2	10		80 - 110
4.00 x 350	2	10		110 - 140
5.00 x 350	2	10		140 - 180