



# Cast Iron, Non Ferrous & Others



## Code & Specification

ASME SFA/AWS A5.15 E NiCu-7

## Description

**BLUME<sup>®</sup> E NiCu-7** is a Monel electrode for joining and surfacing of nickel copper alloys. Low iron deposit exhibit maximum corrosion resistance. Medium penetration weld. Easily machinable deposit in as welded and stress relieved condition. Passes 180° bend test on monel alloy 400 plate.

## Applications

**BLUME<sup>®</sup> E NiCu-7** welding Monel to itself, to stainless steels or carbon steels. Overlaying on steel to obtain a corrosion resistant surface. Used for refineries, off shore, foundries, chemical and fertiliser plants, heat exchanger, pressure vessel and column manufacturing units, food, pumps & valves manufacturing units.

## Mechanical Properties

	Condition	UTS, Mpa	EL%
Specification	As Welded	490-590	30-40

**Redrying Condition : 150°C (300°F) for 1 Hour**

## Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	S	Cu
≤ 0.08	1.0-3.0	0.20-0.80	≤ 0.015	≤2.5
Ni	Fe			
62.0-68.0	1.0-2.5			

## Packaging

Ø x L	Amperage, A	Wt./Carton	Carton/Box	Net wt./Box
2.5mm x 350mm (3/32" x 14")	40-80	1 kg (2.2 lbs)	10	10 kgs (22 lbs)
3.2mm x 350mm (1/8" x 14")	80-110	1 kg (2.2 lbs)	10	10 kgs (22 lbs)
4.0mm x 350mm (5/32" x 14")	110-140	1 kg (2.2 lbs)	10	10 kgs (22 lbs)

## Approvals



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

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