



Cast Iron, Non Ferrous & Others



Code & Specification

ASME SFA/AWS A5.15 E NiCu-B

Description

BLUME® E NiCu-B is a monel alloy electrode with graphite based coating. Machinable weld is achieved with this electrode. Minimum dilution ensures shallow but sufficient depth of fusion. No preheating required for use.

Applications

BLUME® E NiCu-B is used for repair of cast iron castings. It is well suited for Gears, Machine Parts and Pump Bodies, also used for rebuilding worn surfaces. Main use is to join cast iron to steel and correcting machining errors on castings.

Mechanical Properties

	Condition	Hardness (3 Layer), BHN
Specification	As Welded	200 max

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

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	S	Cu
0.35-0.55	≤ 2.30	≤ 0.75	≤ 0.025	≤ 0.03
Ni	Fe			
60.0-70.0	3.0-6.0			

Packaging

ø x L	Amperage, A	Wt./Carton	Carton/Box	Net wt./Box
2.5mm x 350mm (3/32" x 14")	45-60	1 kg (2.2 lbs)	10	10 kgs (22 lbs)
3.2mm x 350mm (1/8" x 14")	90-110	1 kg (2.2 lbs)	10	10 kgs (22 lbs)
4.0mm x 350mm (5/32" x 14")	120-150	1 kg (2.2 lbs)	10	10 kgs (22 lbs)

Approvals



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

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