

MIDALLOY NI-MAX 187 COATED ELECTRODE

CLASSIFICATION

- AWS/SFA 5.6 Class ECuNi/ASME SFA 5.6 Class ECuNi ASME SEC IX, F34

DESCRIPTION

- Midalloy NI-MAX187 coated electrode is an all-position, coated electrode used for joining wrought or cast alloys types 70/30, 80/20, 90/10 copper-nickel to themselves or each other.
- UNS# W60715
- ISO ECu7158 (SCuNi30)

APPLICATION

- Joining similar copper-nickel alloys to themselves or each other as well as the clad side of copper-nickel clad steels.
- Used for marine and desalination applications due to good corrosion resistance to sea water.
- Used for dissimilar welds between copper-nickel alloys and nickel alloys; such as nickel 200.

TYPICAL CHEMISTRY

C	Mn	Fe	P	S	Si	Cu	Ni	Pb	Ti	Others
.03	1.8	.62	.009	.006	.35	BAL	30.5	.002	.20	<0.05

TYPICAL MECHANICAL PROPERTIES

Tensile Strength	54,500 PSI
Yield Strength	37,500 PSI
Elongation	28%

RECOMMENDED WELDING PARAMETERS

Diameter	3/32"	1/8"	5/32"	3/16"
Process	SMAW	SMAW	SMAW	SMAW
Voltage	24-28	26-30	28-32	28-32
Amperage Flat	70-85	65-100	110-140	120-160
Amperage Vertical/Overhead	65-75	65-90	100-120	110-130

STANDARD PACKAGING

- 3/32" – 8 lb. Can, 48 lb. Carton
- 1/8", 5/32", 3/16" – 10 lb. Can, 60 lb. Carton

12-1-08

The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such products at any time without notice.

Office and Corporate Warehouse
 630 Axminister Drive
 Fenton, MO 63026 • 636-349-6000 • 800-776-3300
 Fax 636-349-2240

