

## MIDALLOY NI-MAX 190 COATED ELECTRODE

### CLASSIFICATION

- AWS/SFA 5.11 Class ENiCu-7/ASME SFA 5.11 Class ENiCu-7 ASME SEC IX, F42

### DESCRIPTION

- Midalloy NI-MAX190 coated electrode is an all-position, coated electrode used for joining UNS number 04400 alloys to themselves
- UNS# W84190
- ISO 14172 comparison classification ENi4060

### APPLICATION

- Midalloy NI-MAX 190 is used for joining nickel, copper alloys (UNS 04400) to themselves.
- Because the weld metal is resistant to corrosion by sea water, salts, and reducing agents, this product can be used to overlay steel to produce a nickel-copper barrier.
- Midalloy NI-MAX 190 can be used to weld dissimilar applications such as nickel 200 to copper-nickel alloys.

### TYPICAL CHEMISTRY

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Ti	Others
.03	3.4	.95	.009	.006	.9	28.2	66.2	.05	.25	<0.5

### TYPICAL MECHANICAL PROPERTIES

Tensile Strength	75,500 PSI
Yield Strength	52,000 PSI
Elongation	39%

### 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

