

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

Table with 11 columns: C, Mn, Fe, P, S, Si, Cu, Ni, Pb, Ti, Others. Values range from .03 to 30.5.

TYPICAL MECHANICAL PROPERTIES

Table with 2 columns: Property (Tensile Strength, Yield Strength, Elongation) and Value (54,500 PSI, 37,500 PSI, 28%).

RECOMMENDED WELDING PARAMETERS

Table with 5 columns: Diameter, Process, Voltage, Amperage Flat, Amperage Vertical/Overhead. Values vary by diameter (3/32, 1/8, 5/32, 3/16).

STANDARD PACKAGING

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

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