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

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Midalloy