

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

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