GB/T 13814 ENi4060

AWS A5.11 ENiCu-7

EN ISO 14172-ENi4060

# AK ENiCu-7

**Description:** Low hydrogen type of manual electrode,nominal composition is 66%Ni-30%Cu-3%Mn-1%Fe.is Ni-Cu type of manual electrode;With proper amount of Mn and Ti to effectively reduce heat cracking and blowholes; Stable arc, beautiful weld bead appearance,few spatter,easy slag removal, Excellent blowhole resistance and stable deposited metal mechanical properties.

**Application:** Suitable for welding Ni-Cu alloy,such as Monel400/404. ASTMB127 andetc;Can also be used for dissimilar welding of steel and Ni-Cu alloy, or buildup welding on steel surface;Used in heat exchanger, pipe, vessel and evaporator in offshore engineering. Petrochemical industry,and power plant industry..

## Typical Chemical Compostion(%):

| | C | Si | Mn | S | P | Fe | Ni | Cu | TI |
|---|---|---|---|---|---|---|---|---|---|
| **Requirement** | 0.15 | 1.50 | 4.00 | 0.015 | 0.02 | 2.50 | 62-69 | 27-34 | 1.0 |
| **Actual Result** | 0.021 | 0.83 | 3.30 | 0.008 | 0.010 | 0.50 | 67.4 | 27.3 | 0.42 |

## Typical Mechanical Properties:

| | Tensile Strength (MPa) | Yield Stress ( MPa) | Elongation (%) | Impact Values ( J) |
|---|---|---|---|---|
| **Requirement** | ≥480 | —— | 22 | |
| **Actual Result** | 485 | 360 | 30 | |