


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA GAMMA 400-E	
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CLASSIFICATION

ASME II C SFA 5.11 / AWS A 5.11:	ENiCu-7
EN ISO 14172:	E Ni 4060 (NiCu30Mn3Ti)
UNS number:	W84190
Material number:	2.4366
ASME IX Qualification	QW432 F-N° 42

DESCRIPTION

- Basic coated nickel base electrode with fully-alloyed cored wire
- Joining and repairing of matching Ni-Cu base materials
- The electrode distinguishes itself by a soft arc, easy slag removal and regular weld beads.
- Construction of sea water apparatus, in chemical and petrochemical industry, shipyards, desalination plants

APPLICATIONS

WA GAMMA 400-E is specially designed for cladding and weld overlay. A full NiCu-7 composition is achieved in two layers.

WA GAMMA 400-E is also suitable for welding nickel copper alloys of similar analysis and for heterogeneous welds between alloy 400 and other alloys or steels

Examples:

Alloy	UNS	EN Designation	Material Number
400	N04400	NiCu30Fe	2.4360
405	N04405	LC-NiCu30Fe	2.4361
	N05500	G-NiCu30Nb	2.4365
K500	N65500	NiCu30Al	2.4375

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cu	Ti	Fe	S	P	Ni
0.04	3.2	0.7	29.0	0.5	1.2	0.005	0.01	Bal.

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
480	200	27	+20°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
480	350	35	+20°C: 100

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Current [A]	50-75	80-110	90 -130

= +

Re-drying: if necessary 1h at 350°C.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE
ASME IX: 1G, 2G, 2F, 3G, 4G

PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Weight/box [kg]	4.0	5.0	5.0

Other packaging and other sizes: please contact us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.