


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

ASME II C SFA 5.11 / AWS A 5.11:	ENiCu-7
EN ISO 14172:	E-Ni4060 (NiCu30Mn3Ti)
UNS-base material:	W84190

#### DESCRIPTION

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

#### APPLICATIONS

- Joining and repairing of matching Ni-Cu base materials

#### Base materials

UNS	Alloy	EN	Material N°
C70600	CuNi90-10	CuNi10Fe1Mn	2.0872
C71500	CuNi70-30	CuNi30Mn1Fe	2.0882
N04400	400	NiCu30Fe	2.4360
N05500	K-500	NiCu30Al	2.4375

#### TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cu	Fe	Ti	Ni
0.04	0.7	3.2	29.0	1.0	0.5	Bal.

#### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

R <sub>m</sub> [MPa]	R <sub>p0.2%</sub> [MPa]	A <sub>5</sub> [%]	CVN [J]
480	350	35	+20°C: 100

#### OPERATING CONDITIONS

Electrode ØxL [mm]	2,5x300	3,2x350	4,0x350
Current [A]	50-70	70-100	90-120
= +	70 V		

Re-drying: 2 h at 250-300°C. Joints to weld must be clean, exempt from grease, cracks.

Guide electrodes with a slight declination, weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2 times core wire diameter).

#### WELDING POSITIONS

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

#### PACKAGING

Electrode ØxL [mm]	2,5x300	3,2x350	4,0x350
Weight/box [kg]	4	5	5
Piece/box	~ 216	~ 143	~ 94

Other packaging and other sizes: please consult 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.