

Characteristics:

LKE-NiCu-7 is a low hydrogen type covered electrode. Excellent weldability and stress corrosion resistance are obtained.

Applications:

It is suitable for Monel 400, valves, pump and propeller of petrochemical plant.

Notes on Usage:

1. Dry the electrode at 350-400 °c for 30-60 minutes.
2. Use small amperage and keep the arc as short as possible.
3. Flat position welding is recommended.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Ni	Cu	Ti	Fe
0.04	3.18	0.68	0.002	0.003	66.50	Bal.	0.18	0.51

Typical mechanical properties of weld metal

TS N/mm ²	EL %
505	43

Welding position:



Sizes and recommended current range (DC <+>)

Diameter (mm)		2.6	3.2	4.0	4.8
Length (mm)		300	350	350	350
Amps	F	60-90	80-110	110-150	140-180
Weight per pack(kg)		5	5	5	5
Weight per carton (kg)		20	20	20	20