

D&H 1250

CODIFICATION: **AWS :** SFA 5.11 ENiCu-7

CHARACTERISTICS AND APPLICATIONS:

D&H 1250 is a basic coated electrode depositing monel weld metal. Ideal for welding of monel to monel, Ni-Cu alloys to themselves, Ni-Cu alloy to steels, for welding clad side of Ni-Cu clad steel and for surfacing on steel parts for service against corrosion by sea water, chlorinated solvents, sulphuric acid and alkalis; ideal for marine, chemical, food, dairy and oil refining industries.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	Ni	Al	Ti	Fe	Cu
Percent :	0.05	2.80	0.50	66.0	0.60	0.60	1.30	Balance

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L=4d)%
505	34.0

CURRENT & PACKING DATA: DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range (Amps)	:	150-180	120-150	80-110	60-70
Weight/Carton (Kgs)	:	2.5	2.5	2.5	2.5

APPROVAL: BHEL, NPCIL

PRECAUTIONS:

1. Redry the electrodes at 300-325°C for one hour.
2. Use DC(+) and minimise heat input by using low current and stringer bead.
3. Wherever possible weld in flat position only.