



D&H MONEL

CODIFICATION: AWS : SFA 5.15 ENiCuB

CHARACTERISTICS AND APPLICATIONS :

D&H Monel is a nickel-copper alloy electrode depositing a monel weld metal for welding of cast irons. The weld metal bonds easily and strongly with the cast iron. Ideal for repairing defects in foundry cast iron castings, repairing of cracks, broken parts of cast iron, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Ni	Fe	Cu
Percent	: 0.42	1.0	0.6	64.0	3.5	Balance

WELD METAL HARDNESS: 150-175 VPN

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 140-170	100-130	70-100	50-70
Weight/Carton (kgs)	: 2.5	2.5	2.5	2.5

PRECAUTIONS:

1. Ensure the electrode are dry. In case of moisture pick-up, redry the electrodes at 120°C for one hour.
2. Over heating of casting should be avoided by putting intermittent weld beads
3. Allow the weld to cool slowly.