

MMA electrodes  
nickel and copper alloys

# STARBLAZE PRIME NiCu7

- ★ Alloyed core, smooth and forceful arc.
- ★ Universal monel repairing, joining, problem solver.
- ★ Weld metal free from porosities.
- ★ Weld metal corrosion resistant to sea water, salts and reducing acids.

**Classification**                      **AWS A5.11 : E NiCu-7**                      **EN ISO 14172 : E Ni 4060(NiCu30Mn3Ti)**

**Description and applications**                      Specially designed basic type electrode for welding or facing of Monel alloys 400, R 405, K 500 and Monel clad steels. Excellent mechanical properties. The weld metal is free from porosity and resistant to corrosion by sea water, salts and reducing acids. Suitable for dissimilar welding applications for Monel includes joints between monel, nickel-copper alloys and carbon steel, low alloy steel, copper and copper-nickel alloys. Suitable working temperature from -196°C to +450°C. Weld deposit similar to E NiCu7.

**Base materials**                      2.4360 (NiCu30Fe); 2.4375 (NiCu30Al)  
UNS NO4400; UNS N 055 00

**Typical weld metal Chemical Composition (%)**

C	Mn	Fe	P	S	Si	Ni	Cu
0.03	3.50	2.00	0.015	0.010	0.40	Rem.	29.00

**All weld metal Mechanical properties (Typical)**

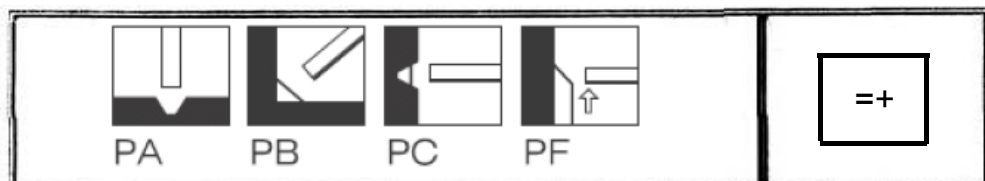
Yield strength $R_p$ (N/mm <sup>2</sup> )	Tensile strength $R_m$ (N/mm <sup>2</sup> )	Elongation $A_5$ (%)	Hardness (BHN)
≥230	≥490	≥30	140 – 170

**Amperes (A)**

2.50mm	3.15mm	3.20mm	4.00mm
50-70	80-100	80-100	100-130

**Welding instruction**                      Keep dry and avoid condensation. Re-dry at 350°C for 1-2 hours, 3 times max. Preheat sections above 25 mm. Guide the electrode at a steep angle keeping the arc length short. Clean the slag completely between passes. Allow slow cooling to room temperature.

**Welding Position**



**Stellaris Specialities India Ltd.**

(Division: StarBlaze India)

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