

Lastek 967

Welding of monel®400

CLASSIFICATION

DIN 1736 : SG NiCu30MnTi

AWS A5.14 : ER NiCu-7

GENERAL DESCRIPTION

Gas tungsten arc filler rod for joining monel and monel clad steel.

Also applicable for overlaying mild steel.

Seawater resistant (especially with flowing seawater), corrosion resistant.

Can be used for TIG welding cast iron.

APPLICATIONS

Chemical industry, food industry, shipbuilding, petrochemistry.

Stirring devices, pickling baths, heat exchangers, pump-parts, distilling columns, furnace muffles.

Repair of flaws in cast iron, joining of broken cast iron parts.

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : < 0.15	Cu : 28.00 - 34.00	Fe : 0.50 - 2.50	Mn : 2.00 - 4.00	Si : < 1.00
Ti : 1.50 - 3.50	S : < 0.015	Ni : > 62.00		

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 500 MPa	≥ 35%	

GENERAL INFORMATION

Welding positions NA

Shielding gas Argon

Packing 5 kg in a cardboard box

Polarity DC, with the torch on the negative pole.

Diameter (mm) 1.6 2.4

Length (mm) 1000 1000

Tips & tricks

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.