

AI-0390

Specifications

AWS/ASME A5.6.76 E NiCu-7

DIN 1736 S-NiCu30MnTi

MIL E-21562 Type MIL-RN60 & EN60

Description and Applications

AI-0390 is an electrode which is used for welding of MONEL* alloys 400 and 404 to themselves and each other. It can also be used as an overlay on steel after an initial layer of **AI-0399**. Dissimilar welding applications include joining MONEL* alloys to Nickel 200 and joining MONEL* alloys and Nickel 200 to copper-nickel alloys. This alloy has a high strength, good weldability and excellent temperature and corrosion resistance over a wide range of temperatures.

Applications include: Valves, shafts, pumps, marine fixtures, electrical and electronic components, processing and refining equipment, heat exchangers etc.

Typical Weldmetal Analysis

C	Mn	Si	Cu	Ni	Fe	Ti	S
<0.02	3.50	0.3	29	Bal	0.10	2.20	0.005

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	500MPa
Yield Strength (0.2%)	310MPa
Elongation	43% (4d)

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC +ve	60-80
3.2	DC +ve	80-120
4.0	DC +ve	120- 150

Also available as Solid MIG Wire **AI-1790** and **TIG AI-0390T**

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4F) Horizontal overhead position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

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