

Inweld NA 187

AWS A5.6 ECuNi

Chemical Composition of Inweld NA 187

Fe	Pb	Cr	Ni	Mo	Mn	Si	P	S	Ti	Cu
0.62	0.002	---	30.5	---	1.8	0.35	0.009	0.004	0.02	Balance

Single values are maximum unless otherwise specified.

Description and Applications

Inweld Nickel 187 is a copper-nickel, all-position electrode for shielded metal arc welding of wrought or cast alloys of similar composition as well as 80 Cu + 20 Ni and 90 Cu + 10 Ni alloys. It is also used for the clad side of copper-nickel clad steels. This filler metal is widely used in marine applications because of its good resistance to the corrosive effects of sea water.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	54,500 psi
Yield Strength:	37,500 psi
Elongation:	28%

Recommended Parameters

SMAW (DC Electrode +)

<u>Wire Diameter</u>	<u>Amperage</u>
3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

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