

STARCAST NiCu

TOP FEATURES

- The weld metal is machinable
- Short beads technic is recommended in order to have the lowest heat input.
- Easy arc striking, stable arc, finely-rippled bead surface.

CLASSIFICATION

AWS A5.15 ENiCu-B
EN ISO 1071-A E C NiCu-B 1

CURRENT TYPE

AC, DC-, DC+

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	S	Ni	Cu	Fe
0.35-0.55	≤2.30	≤0.75	≤0.025	60-70	25-35	3-6

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
AWS A5.15	AW	not specified	not specified	not specified	not specified
EN ISO 1071-A	AW	≥190	≥300	≥15	not specified
Typical values	AW	≥190	≥300	≥15	not specified

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	70-120
4.0 x 350	100-140

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	VPMD	70	2.3	W100289021
4.0 x 350	VPMD	48	2.4	W100289022

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.