



blume®

ENiCu-B

Nickel and Nickel Alloy Stick Electrodes



CONFORMANCE

ASME SFA/AWS A5.15 ENiCu-BI

WELDING POSITION

All Position

DESCRIPTION

BLUME® ENiCu-B is a monel alloy electrode with graphite based coating. Machinable weld is achieved with this electrode. Minimum dilution ensures shallow but sufficient depth of fusion. No preheating required for use.

TYPICAL APPLICATION

BLUME® ENiCu-B is used for repair of cast iron castings. It is well suited for Gears, Machine Parts and Pump Bodies, also used for rebuilding worn surfaces. Main use is to join cast iron to steel and correcting machining errors on castings.

UNDILUTED WELD METAL ANALYSIS (WT%)

	C	Mn	Si	S	Cu
As Welded	0.35-0.55	< 2.30	< 0.75	< 0.025	≤0.03

SUGGESTED WELDING PARAMETERS

Ø x L	Amps
3/32" x 14" (2.5mm x 350mm)	60 - 100
1/8" x 14" (3.2mm x 350mm)	90 - 120
5/32" x 14" (4.0mm x 350mm)	130 - 180



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PACKAGING

Ø x L	Wt./Carton	Carton/Box	Net wt./Box
3/32" x 14" (2.5mm x 350mm)	2.2 lbs (1 kg)	10	22 lbs (10 kgs)
1/8" x 14" (3.2mm x 350mm)	2.2 lbs (1 kg)	10	22 lbs (10 kgs)
5/32" x 14" (4.0mm x 350mm)	2.2 lbs (1 kg)	10	22 lbs (10 kgs)