



D&H 1250

CODIFICATION: **AWS :** SFA 5.11 ENiCu-7
 EN ISO : 14172 E Ni 4060

CHARACTERISTICS AND APPLICATIONS:

D&H 1250 is a basic coated electrode depositing monel weld metal. Ideal for welding of monel to monel, Ni-Cu alloys to themselves, Ni-Cu alloy to steels, for welding clad side of Ni-Cu clad steel and for surfacing on steel parts for service against corrosion by sea water, chlorinated solvents, sulphuric acid and alkalies; ideal for marine, chemical, food, dairy and oil refining industries.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

| Element : | C | Mn | Si | Ni | Al | Ti | Fe | Cu |
|-----------|------|------|------|------|------|------|------|---------|
| Percent : | 0.05 | 2.80 | 0.50 | 66.0 | 0.60 | 0.60 | 1.30 | Balance |

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

| UTS (MPa) | Elongation (L=5d)% |
|--------------|-----------------------|
| 505 | 34.0 |

CURRENT & PACKING DATA: DC(+)

| | | | | | |
|-------------------------|---|---------|---------|----------|---------|
| Size (mm) | : | 5x350 | 4x350 | 3.15x350 | 2.5x350 |
| Dia x Length | | | | | |
| Current Range (Amps) | : | 150-180 | 120-150 | 80-110 | 60-70 |
| Weight/Cartron (Kgs) | : | 2.5 | 2.5 | 2.5 | 2.5 |

APPROVALS: BHEL, CE, NPCIL

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 300-325°C for one hour.
2. Use DC(+) and minimise heat input by using low current and stringer bead.