

CuNi10Fe

CATEGORY GMAW-GTAW Solid wires

TYPE Copper-Nickel alloyed Mig welding wire

APPLICATIONS This Copper-Nickel weld metal is suitable for welding and cladding CuNi-materials of DIN 17664 and seawater resistant CuZn alloys of DIN 17660 table 3. And also suitable for surfacing on low alloyed and unalloyed steels and grey cast iron.

CLASSIFICATION

AWS	A 5.7: no standard
EN ISO	24373: Cu 7061
DIN: W.Nr.	2.0873
DIN	1733: SG-CuNi10Fe

SUITABLE FOR Cunifer 10, cuni10fe, seawater resistant, marine applications, tubes, pump building, offshore etc.

WELDING POSITIONS:



WELD METAL ANALYSIS %

Mn	Ni	Fe	Si	Cu	Ti	C
0.4-1.0	9.0-12.0	0.50-1.50		Rem	0,30-0.50	

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				20°C	-40°C	-60°C	
AW		>300	34	190			80

AW: As Welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		spool type	Packing	
		Current (A) DC+		kg/spool	kg/pallet
0.8	25-26	80-140	KD-300	15	1080
1.0	26-27	130-200	KD-300	15	1080
1.2	27-28	185-245	KD-300	15	1080

REDRYING TEMPERATURE not required

GAS ACC. ISO 14175 I1 / ArHe 70-30