

## NiCu30Mn Tig

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Solid Nickel based filler metal alloyed with Copper for Tig welding.

**APPLICATIONS** Shipbuilding, seawater evaporation plants, tubes, pump building, offshore etc.

**PROPERTIES** This Nickel - Copper weld metal has properties similar to "Monel 400". It has good strength and resists corrosion in many media, including sea water, salts and reducing acids. The weld metal is not age hardenable and when used to join Monel K-500 it has lower strength than the base metal.

**CLASSIFICATION**

AWS	A 5.14: ER NiCu-7
EN ISO	18274: S Ni 4060
DIN: W.Nr.	2.4377
DIN	1736: SG-NiCu30MnTi

**SUITABLE FOR** 2.4360, 2.4375, NiCu30Fe, NiCu30Al, Monel alloy 400, R405, alloy K500 and dissimilar welding between these alloys.

**APPROVALS** CE approved



**WELD METAL ANALYSIS %**

Mn	Ni	Fe	Si	Cu	Ti	C
< 4.0	62-69	< 2.5	< 1.25	base	1.50-3.0	< 0.15

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				20°C	-40°C	-60°C	
AW	>300	>450	>30	>80			

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing (kg)	
	Current (A) DC-		single	master
1,6 x 1000	50-80		5	25
2.0 x 1000	70-110		5	25
2.4 x 1000	110-180		5	25
3.2 x 1000	150-250		5	25

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** I1