

CATEGORY	GTAW Solid wires		
TYPE	Copper-Nickel alloyed TIG welding wire		
APPLICATIONS	The CEWELD® CuNi10Fe Tig is suitable for welding and cladding CuNi-Materials of ISO 17664 and seawater resistant CuZn alloys of ISO 17660 table 3. And also suitable for surfacing on low alloyed and unalloyed steels and grey cast iron.		
PROPERTIES	Sound, pore free deposits on ferrous and non-ferrous base materials.		
CLASSIFICATION	EN ISO	24373: Cu 7061 / CuNi10	
	F-nr	37	
	W.Nr.	2.0873	
SUITABLE FOR	Cunifer 10, cuni10fe, seawater resistant, marine applications, tubes, pump building, offshore etc.		
APPROVALS	No Approvals Found		

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Ti	Fe	Pb	Ni+Co
0.02	0.1	1.1	0.01	0.01	0.4	1.5	0.01	10

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2}	R _m	A ₅	Impact Energy (J) ISO-V	Hardness
	MPa	MPa	(%)	RT	Brinell Hardness
As Welded /		300	34	190	Avg. 80

WELDING PARAMETERS / PACKING

WELDING PARAMETERS		WELDING PARAMETERS		WELDING PARAMETERS		PACKING		PACKING	
D (MM)	LENGTH (MM)			CURRENT (A) DC-		KG		KG / 5 PACK	
1.6	1000			50-80		5		25	
2.0	1000			70-110		5		25	
2.4	1000			110-180		5		25	
3.2	1000			150-250		5		25	

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1, I3