


CATEGORY	GTAW Solid wires						
TYPE	Tig welding wire for CuNi30Fe 2.0837						
APPLICATIONS	This Copper-Nickel weld metal is widely used for marine and desalination applications. Dissimilar welding applications for this alloy are joints between Monel alloys or Nickel 200 and Copper-Nickel alloys. Often used for surfacing on steel by using Ceweld NiTi-3 as a barrier layer. Shipbuilding, seawater evaporation plants, tubes, pump building, offshore, desalting equipment and parts etc.						
PROPERTIES	Sound, pore free deposits on ferrous and non-ferrous base materials offering excellent resistance to corrosion in sea water.						
CLASSIFICATION	AWS	A 5.7: ERCuNi					
	EN ISO	24373: Cu 7158 / CuNi30Mn1FeTi					
	F-nr	34					
	W.Nr.	2.0837					
SUITABLE FOR	(Monel 67): Wrought and cast alloys of 70-30, 80-20 and 90-10 copper nickel alloys, Monel alloy 450, Nickel 200, CuNi10Fe, CuNi20Fe (2.0878), CuNi30Fe (2.0882).						
APPROVALS	No Approvals Found						
WELDING POSITIONS:							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)							
Si	Mn	P	Ti	Fe	Pb	Ni+Co	S
0.2	0.5	0.01	0.4	0.6	0.01	31	0.01
ALL WELD MECHANICAL PROPERTIES							
Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT	Hardness Brinell Hardness		
As Welded /	200	420	36	200	Avg. 115		
WELDING PARAMETERS / PACKING							
WELDING PARAMETERS		WELDING PARAMETERS		WELDING PARAMETERS		PACKING	PACKING
D (MM)	LENGTH (MM)	CURRENT (A) DC-	KG/PACK	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						