AUTOMIG NiCu-7 / TIGFIL NiCu-7

GMAW/GTAW
NICKEL ALLOYS

MONEL SOLID WIRE FOR NICKEL-COPPER ALLOY WELDING

CLASSIFICATION :	EN ISO 18274	AWS A/SFA 5.14	APPROVALS :
	SNi 4060	ERNiCu-7	-

KEY FEATURES :

- Monel solid wire
- Typical 65Ni/30Cu/3Mn/2Ti alloy
- Easily machinable deposit in as welded and stress relieved condition
- Low iron in the deposit exhibit maximum corrosion resistance
- Radiographic weld quality

WELDING POSITION :

GMAW: DCEP
GTAW: DCEN

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
GMAW: Ar or Ar/He	15-22	10-20
GTAW: Ar	10-15	-

TYPICAL APPLICATIONS :

- Welding Monel and NiCu alloys to itself, to mild and low alloyed steels
- Overlaying on steel to obtain a corrosion resistant surface
- Welding of ASTM B127/163/164/165
- Heat exchanger, Piping, Vessels, Salt purification
- Food, Pumps and Valves manufacturing units

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Fe	S	P
Specification	0.15 max	4.0 max	2.5 max	0.015 max	0.02 max
	Si	**Cu**	**Al**	**Ti**	**Ni**
Specification	1.25 max	Bal.	1.25 max	1.5-3.0	62.0-69.0

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Typical	As Welded	480	32

Mechanical properties will vary with the type of shielding gas used.

PACKING DATA :

	Ø, mm		Kg/Spool	
Automig NiCu-7	1.2		12.5	
	1.6		12.5	
Tigfil NiCu-7	**Ø x L, mm**	**Primary Box, Kg**	**No. of Primary Boxes**	**Net Wt. of Carton, Kg**
	2.0 x 1000	5	4	20
	2.4 x 1000	5	4	20
	3.2 x 1000	5	4	20

EQUIVALENT :

SMAW Electrode: **Supermonel**