



TIGFIL NiCu-7

GTAW NICKEL ALLOYS

AWS A/SFA 5.14 ERNiCu-7

CLASSIFICATION:

EN ISO 18274
S Ni 4060 (Ni Cu 30Mn 3Ti)

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

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


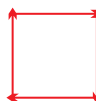
CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Fe	Si	Cu	Al	Ti	Ni
0.15 max	4.0 max	2.5 max	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	490	32

PARAMETERS - PACKING DATA:

Ø, mm	Net Wt., Kg		
2.0 x 1000	20	 DCEN	All Positions 
2.4 x 1000	20		
3.15 x 1000	20		
		STORAGE / HANDLING : Keep dry during storage and handling	

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.