



TIGFIL CuNi

GTAW
COPPER ALLOYS



SOLID FILLER ROD FOR WELDING COPPER – NICKEL ALLOYS

CLASSIFICATION :	EN ISO 24373	AWS A/SFA 5.7	APPROVALS :
	Scu 7158	ERCuNi	-

KEY FEATURES :

- Copper-Nickel solid filler rod
- Typical 70Cu-30Ni type alloy
- No preheating is required
- Radiographic quality welds

WELDING POSITION :		DCEN
Shielding Gas	Gas Flow Rate, LPM	
Ar	8-15	

TYPICAL APPLICATIONS :

- Welding of wrought and cast 70/30, 80/20, 90/10 copper-nickel alloys to themselves or to each other
- Clad side of copper-nickel clad steels
- Surfacing applications where high resistance to corrosion, erosion or cavitation is required

STORAGE / HANDLING :

Keep dry during storage and handling

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	Mn	Fe	Si	Ni+Co	P	Pb	Ti	Cu
Specification	1.0 max	0.40-0.75	0.25 max	29.0-32.0	0.02 max	0.02 max	0.20-0.50	Bal.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	Brinell Hardness, HBW
Specification	As Welded	345 min	60-80

PACKING DATA :

Ø x L, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
1.6 x 1000	5	4	20
2.0 x 1000	5	4	20
2.4 x 1000	5	4	20
3.2 x 1000	5	4	20

