



AUTOMIG CuNi

GMAW COPPER ALLOYS

AWS A/SFA 5.7 **ERCuNi**

CLASSIFICATION:

EN ISO 24373

SCu 7158 (Cu Ni30 Mn1 FeTi)

KEY FEATURES:

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

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



CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

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

MECHANICAL PROPERTIES OF ALL WELD METAL:

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

PARAMETERS - PACKING DATA:

| Ø, mm | Kg/Spool | | |
|-------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------|
| 0.8 | 12.5 |  DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box | All Positions  |
| 1.2 | 12.5 | | |
| 1.6 | 12.5 | | |

| Shielding Gas | Gas Flow Rate, LPM |
|---------------|--------------------|
| 75Ar/25He | 15-25 |