

## MONEL® Filler Metal 67

**MONEL Filler Metal 67** is used for oxyacetylene, gas-tungsten-arc, gas-metal-arc, and submerged-arc welding of MONEL alloy 450 (70/30 Copper-Nickel) and other copper-nickel alloys. It is used for surfacing of steel if a barrier layer of Nickel Filler Metal 61 is first applied. If applied by the submerged-arc process, MONEL Filler Metal 60 can be used for the barrier layer. Submerged-arc welding with MONEL Filler Metal 67 is done with INCOFLUX 8 Submerged Arc Flux.

The copper-nickel weld metal has excellent resistance to corrosion in sea water, and is widely used for marine and desalination applications.

Dissimilar-welding applications for MONEL Filler Metal 67 are joints between MONEL alloys or Nickel 200 and copper-nickel alloys.

### Specifications

AWS A5.7 ERCuNi (UNS C71581)  
 ASME II, Part C, SFA-5.7, ERCuNi (UNS C71581)  
 ASME IX, F-No.34  
 \*BS 2901 (C18)  
 \*DIN 1733 SG-CuNi30Fe (2.0837)  
 \*(EN) ISO SCu 7158 (CuNi30)  
 \*Supply to these specifications available upon request  
 For manufacture to ASME III (NCA3800, NB2400), MIL, and other specifications please refer your inquiry to the Technical Department prior to order placement.

### Approvals

VdTUV 4528.00; 4529.00  
 Other approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

<b>Limiting Chemical Composition</b>	Ni+Co .....	29.0-32.0	Si .....	0.25 max.
	C .....	0.04 max.	Ti .....	0.20-0.50
	Mn .....	1.0 max.	P .....	0.02 max.
	Fe .....	0.40-0.75	Pb .....	0.02 max.
	S .....	0.01 max.	Others .....	0.50 max.
	Cu .....	Remainder		

<b>Minimum Mechanical Properties</b>	Tensile Strength, psi	50,000
	MPa	345
	Elongation, (4d) %	30

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

### Available Product Forms

<b>mm</b>	0.8	0.9	1.0	1.14	1.2	1.6	2.4	3.2
<b>in</b>	0.030	0.035	0.040	0.045	0.047	0.062	0.093	0.125

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)

