

CuNi10Fe TIG

CATEGORY GMAW-GTAW Solid wires

TYPE Copper-Nickel alloyed Tig welding wire

APPLICATIONS This Copper-Nickel weld metal is suitable for welding and cladding CuNi-materials of DIN 17664 and seawater resistant CuZn alloys of DIN 17660 table 3. And also suitable for surfacing on low alloyed and unalloyed steels and grey cast iron.

PROPERTIES Sound, pore free deposits on ferrous and non-ferrous base materials

CLASSIFICATION

AWS	A 5.7: no standard
EN ISO	24373: Cu 7061
DIN: W.Nr.	2.0873
DIN	1733: SG-CuNi10Fe

SUITABLE FOR Cunifer 10, cuni10fe, seawater resistant, marine applications, tubes, pump building, offshore etc.

WELDING POSITIONS:



WELD METAL ANALYSIS %

Mn	Ni	Fe	Si	Cu	Ti	C
0.4-1.0	9.0-12.0	0.50-1.50		Rem		

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				20°C	-40°C	-60°C	
AW		>300	34	190			80

WELDING PARAMETERS ? PACKING

D (mm)	Welding Parameters			Packing	
	Length (mm)	Current (A) DC-		kg	kg / 5 pack
1.6	1000	50-80		5	25
2.0	1000	70-110		5	25
2.4	1000	110-180		5	25
3.2	1000	150-250		5	25

REDRYING TEMPERATURE not required

GAS ACCORDING EN 14175: I1