

CuNi30Fe Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Copper-Nickel alloyed Tig filler metal.

APPLICATIONS This Copper-Nickel weld metal is widely used for marine and desalination applications. Dissimilar welding applications for this alloy are joints between Monel alloys or Nickel 200 and Copper-Nickel alloys. Often used for surfacing on steel by using Ceweld NiTi-3 as a barrier layer. Shipbuilding, seawater evaporation plants, tubes, pump building, offshore, desalting equipment and parts etc.

CLASSIFICATION

AWS	A 5.7: ER CuNi
EN ISO	24373: Cu 7158
DIN: W.Nr.	2.0837
DIN	1733: SG-CuNi30Fe

SUITABLE FOR (Monel 67): Wrought and cast alloys of 70-30, 80-20 and 90-10 copper nickel alloys, Monel alloy 450, Nickel 200, CuNi10Fe, CuNi20Fe (2.0878), CuNi30Fe (2.0882).

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cu	Ni	Fe	Ti
<0.04	<1.0	<0.25	rem	29.0-32.0	0.40-0.70	0.20-0.50

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	>200	> 420	36	240			240

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Length (mm)	Current (A) DC-	kg/pack	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 ACC. ISO 14175 I1