



AUTOMIG NiCu-7

GMAW NICKEL ALLOYS

AWS A/SFA 5.14 ERNiCu-7

CLASSIFICATION:

EN ISO 18274
S Ni 4060 (Ni Cu 30Mn 3Ti)

KEY FEATURES:

- Monel solid wire
- Typical 65Ni/30Cu/3Mn/2Ti alloy
- Easily machinable deposit in as welded and stress relieved condition
- Low iron in the deposit exhibit maximum corrosion resistance
- Radiographic weld quality

TYPICAL APPLICATIONS:

- Welding Monel and NiCu alloys to itself, to mild and low alloyed steels
- Overlying on steel to obtain a corrosion resistant surface
- Welding of ASTM B127/163/164/165
- Heat exchanger, Piping, Vessels, Salt purification
- Food, Pumps and Valves manufacturing units


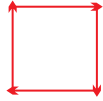
CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Fe	Si	Cu	Al	Ti	Ni
0.15 max	4.0 max	2.5 max	1.25 max	Bal.	1.25 max	1.5-3.0	62.0-69.0

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	490	32

PARAMETERS - PACKING DATA:

∅, 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	15-22