



MIG CUNI10

Old reference: MIG CuNi90.10

Classification

ISO 24373 : S Cu 7061 (CuNi10)

Description & Applications

Solid wire for GMAW of Copper-Nickel alloys types CuNi90/10.

Main applications: For offshore applications, seawater desalination plants, for ship building, in the chemical industry.

Base materials:

UNS	Alloy	DIN	Material N°
C70600	CuNi90/10	CuNi10Fe1Mn	2.0872

Typical Chemical Composition (%)

	Fe	Mn	Ni+Co	P	Pb	Si	C	Ti	S	O/T	Cu
Min	0.5	0.5	9.0					0.1			
Max	2.0	1.5	11.0	0.02	0.02	0.2	0.05	0.5	0.02	0.4	Rem.
Type	1.4	0.8	10.5	0.004	0.01	0.02	0.01	0.4	0.004	<0.4	Rem.

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	-	-	-
Max	-	-	-
Type	150	320	26

Welding Current & Instructions

	Ø (mm)	Welding parameters		Shielding gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	120 - 180	20 - 22	ISO 14175: I1 (100% Ar) I2 (100% He) I3 (Ar+ 5-30%He) 12-18 l/min
	1.0	180 - 220	22 - 24	
	1.2	220 - 250	24 - 26	

Preheating of massive parts between 200°C (>6mm) up to 500°C (>15mm).

FT En-MU12-251211

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Fumes: Consult information on MSDS, available upon request.

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