MIG CUNI30

Old reference: MIG CuNi30

Classification

AWS A5.7 : ERCuNi

ISO 24373 : S Cu 7158 (CuNi30Mn1FeTi)

Description & Applications

Solid wire for GMAW of different Copper-Nickel alloys types as CuNi70/30, CuNi80/20 and CuNi 90/10.

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
	CuNi80/20	CuNi20Fe	2.0878
C71500	CuNi70/30	CuNi30Mn1Fe	2.0882

Typical Chemical Composition (%)

	Fe	Mn	Ni+Co	P	Pb	Si	C	Ti	S	O/T	Cu
Min	0.40	0.5	29.0					0.20			
Max	0.70	1.0	32.0	0.02	0.02	0.25	0.04	0.50	0.01	0.50	Rem.
Type	0.60	0.80	31.0	0.002	0.005	0.05	0.03	0.40	0.002	<0.50	Rem.

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
Min	-	-	-
Max			
Type	240	400	32

Welding Current & Instructions

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

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

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