MIG NI60

Classification

AWS A5.14 : ERNiCu-7 ISO 18274 : S Ni 4060 (NiCu30Mn3Ti)

Description & Applications

Solid wire for GMAW of “Monel” alloy (alloy 400) for components for chemical and petrochemical installations, for sea water and off shore applications. Excellent resistance against corrosion. Recommended for steels/ Copper-Nickel or steels/Copper/Copper Nickel alloys assemblies.

Main applications: Chemical industries, ship building, desalination equipments...

Base materials

UNS	Alloy	DIN	Material N°
C70600	CuNi90/10	CuNi10Fe1Mn	2.0872
C71500	CuNi70/30	CuNi30Mn1Fe	2.0882
N04400	400	NiCu30Fe	2.4360
N05500	K-500	NiCu30Al	2.4375

Typical Chemical Composition (%)

	C	Si	Mn	Cu	P	S	Fe	Nb	Al	Ti	Ni
Min				28.0						1.5	62.0
Max	0.15	1.2	4.0	32.0	0.020	0.015	2.5	0.3	1.2	3.0	69.0
Type	0.03	0.40	3.5	29.0	0.010	0.005	0.60	0.02	0.09	2.2	65.0

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	-	-	-	-	-
Max					
Type	320	510	38	+20°C	180

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8 1.0 1.2 1.6	70 - 180 80 - 220 150 - 320 220 - 380	18 - 26 18 - 28 22 - 32 24 - 34	ISO 14175: I1 (100% Ar) I3 (Ar+10-30%He) Z (Ar+He+H+CO_2) 15-20 l/min

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