



# TIG CUNI30

Old reference: TIG CuNi30

## Classification

AWS A5.7 : ERCuNi

ISO 24373 : S Cu 7158 (CuNi30Mn1FeTi)

## Description & Applications

Solid rod for GTAW 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 <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
Min	-	-	-
Max			
Type	240	400	32

## Welding Current & Instructions

Welding mode	Shielding Gas
GTAW = -	ISO 14175: I1 (100% Ar) / I2 (100% He) / I3 (Ar+ 5-30%He) 5-10 L/min

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

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**Fumes:** Consult information on MSDS, available upon request.

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