MIG NI60

Classification

ISO 18274 : S-Ni 4060 (NiCu30Mn3Ti) Material N° : 2.4377
AWS A5.14 : ERNiCu-7

Description & Applications

Solid wire for GMAW for welding alloys like “Monel*”. Used to weld components for chemical and petrochemical installations, for sea water and off shore applications.

Main applications: Petro-chemical and chemical industry.
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Base material:

UNS	Alloy	DIN	N°d’alliage
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	Fe	Ti	Cu	P	S	Ni
0.03	0.4	3.5	0.6	2.2	29.0	<0.01	<0.01	Rem.

All Weld Metal Mechanical Properties

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

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0 1.2	90-160 160-200	24-28 24-28	Ar + He Ar/He + 0.05% CO_2 18-20 l/min

Ind.10

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