TIG NI60

Old reference: TIG Ni60

Classification

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

Description & Applications

Solid rod for TIG welding of “Monel” alloy 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...

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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	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	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon : 3-6 l/min

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