
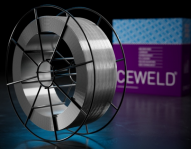


CEWELD NiCu30Mn

TYPE	Solid Nickel based filler metal alloyed with Copper.																
ANWENDUNGEN	Shipbuilding, seawater evaporation plants, tubes, pump building, offshore etc. CEWELD® NiCu30Mn is suitable for dissimilar welding between Nickel 200-201, stainless steel, carbon steel, Inconel and Incoloy alloys, Nickel Copper and Copper nickel alloys.																
EIGENSCHAFTEN	This Nickel - Copper weld metal has properties similar to "Monel 400". It has good strength and resists corrosion in many media, including sea water, salts and reducing acids. The weld metal is not age hardenable and when used to join Monel K-500 it has lower strength than the base metal.																
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCu-7</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 4060(NiCu30Mn3Ti)</td> </tr> <tr> <td>W.Nr.</td> <td>2.4377</td> </tr> <tr> <td>F-nr</td> <td>42</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.14: ERNiCu-7	EN ISO	18274: S Ni 4060(NiCu30Mn3Ti)	W.Nr.	2.4377	F-nr	42	FM	6						
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GEEIGNET FÜR	<p>E Ni 4060 (NiCu30Mn3Ti) 2.4360, 2.4361, 2.4365, 2.4375, (2.0872, 2.0882, 2.0890) NiCu30Fe, NiCu30Al, G-NiCu 30 Nb, LC-NiCu 30 Fe, ASTM B127, B163, B164, B165 UNS N04400 Monel 400, Monel R405, Monel K-500 Alloy K500 and dissimilar welding between these Alloys.</p>																
ZULASSUNGEN																	
SCHWEISSPOSITIONEN																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Ni</th> <th>Ti</th> <th>Cu</th> <th>Al</th> </tr> </thead> <tbody> <tr> <td>0.09</td> <td>1</td> <td>3.5</td> <td>65</td> <td>2</td> <td>30</td> <td>1</td> </tr> </tbody> </table>	C	Si	Mn	Ni	Ti	Cu	Al	0.09	1	3.5	65	2	30	1		
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MECHANISCHE GÜTEWERTE	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>300</td> <td>450</td> <td>30</td> <td colspan="2">70</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT		As Welded	300	450	30	70		HRc
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As Welded	300	450	30	70		HRc											
RÜCKTROCKNUNG	Not required																
GAS ACC. EN ISO 14175	I1																



CEWELD NiCu30Mn

NICU30MN 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417954
D-100	1	8720663417947

NICU30MN 0,9MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417961

NICU30MN 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417978

NICU30MN 1,2MM

Packaging	KG/unit	EanCode
BS-300	13,6	8720663417992
BS-300	15	8720663417985

NICU30MN 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663418005
BS-300	13,6	8720663418012