



CEWELD NiCu30Mn Tig

TYPE GTAW welding wire for Monel 400 and similar alloys.

APPLICATIONS Shipbuilding, seawater evaporation plants, tubes, pump building, offshore etc.

PROPERTIES CEWELD® NiCu30Mn is a Nickel - Copper weld metal and 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.

CLASSIFICATION

| | |
|--------|-------------------------------|
| AWS | A 5.14: ERNiCu-7 |
| EN ISO | 18274: S Ni 4060(NiCu30Mn3Ti) |
| W.Nr. | 2.4377 |
| F-nr | 42 |
| FM | 6 |

SUITABLE FOR

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.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | Ni | Ti | Fe | Cu | Al |
|-----|----|----|----|-----|----|----|-----|
| 0.1 | 1 | 3 | 65 | 2.5 | 2 | 30 | 0.9 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | RT | | |
| As Welded | 315 | 500 | 32 | 100 | | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD NiCu30Mn Tig

| | | | |
|---------------------------|-----------|---------|---------------|
| NICU30MN TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663418036 |
| NICU30MN TIG 1,6 X 914MM | Packaging | KG/unit | EanCode |
| | Tube | 4,54 | 8720663418029 |
| NICU30MN TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663418043 |
| NICU30MN TIG 2,0 X 914MM | Packaging | KG/unit | EanCode |
| | Tube | 4,54 | 8720663417664 |
| NICU30MN TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663418050 |
| NICU30MN TIG 2,4 X 914MM | Packaging | KG/unit | EanCode |
| | Tube | 4,54 | 8720663418067 |
| NICU30MN TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663418074 |
| NICU30MN TIG 3,2 X 914MM | Packaging | KG/unit | EanCode |
| | Tube | 4,54 | 8720663418081 |