

ES TIG NiCu-7

GTAW
ERNiCu-7

ESWECO
The Art of Welding

Description

A nickel-based rod alloyed with about 30% Cu, 2% Ti and 1% Fe for the GTAW of base materials of the same type. It can also be used for joining these alloys to steels. ES TIG NiCu-7 is normally welded with pure Ar as the shielding gas.

Typical applications include heat exchangers, piping, pumps, valves and process vessels in the chemical, offshore and marine industries.

Current

DC (-)

Classifications

SFA/AWS A5.14	ERNiCu-7
DIN 1736	SG-NiCu30MnTi
Werkstoff Nr.	2.4377

Typical all weld metal composition, %

C	Si	Mn	Nb	Ni	Ti	Cu	Fe
0.15	<1.0	3.0	<0.5	65.5	2.3	30.0	1.5

Typical mech. Properties all weld metal

Yield stress, MPa	300
Tensile strength, MPa	530
Elongation, %	45

Charpy V

Test temps, °C	Impact values, J
+20	130
-20	150

Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0