

ES MIG NiCu-7

GMAW
ERNiCu-7

ESWECO
The Art of Welding

Description

ES MIG NiCu-7 is a nickel-based electrode alloyed with about 30%Cu, 2% Ti and 1% Fe for the GMAW of base materials of the same type. It can also be used for joining these alloys to steel. ES MIG NiCu-7 is usually 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	Cu	Ni	Fe	Ti
0.04	0.1	3.5	30.0	bal.	1.0	2.0

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	Wire feed, m/min	Welding current, A	Arc voltage, V
0.8	5-18	70-190	20-27
1.0	6-13	100-200	21-27
1.2	6-10	160-280	24-30
1.6	4-8	200-350	25-32