

❖ Product Description

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| I. A monel mixed solid wire | IV. Max corrosion resistance due to low iron content |
| II. Typical alloy 65Ni/30Cu/3Mn/2Ti alloy | V. Radiographic weld quality |
| III. The deposits are easily machinable in as welded and stress relieved condition | |

❖ Range of Application

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| I. For self-welding of monel and NiCu alloys | III. Heat exchangers, piping vessels, salt purification |
| II. Suitable for overlying on steel to get corrosion resistant surface | IV. Food pumps and valves manufacturing units |

❖ Classification

- AWS/SFA 5.14 ERNiCu-7

❖ % Chemical Composition

Type of Wire		C	Mn	Fe	S	Si	Cu	P	Ni	Al	Ti	Other Elements
ERNiCu-7	Min	-	-	-	-	-	-	-	62.0	-	1.5	-
	Max	0.15	4.0	2.5	0.015	1.25	Bal	0.02	69.0	1.25	3.0	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
As Welded	490	-	32	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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