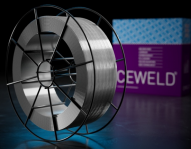




# CEWELD NiCu30Mn

TYPE	Mig-Mag welding wire for Monel 400 ( 500 )														
APPLICATIONS	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.														
PROPERTIES	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 then the base metal.														
CLASSIFICATION	<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>F-nr</td> <td>42</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> <tr> <td>W.Nr.</td> <td>2.4377</td> </tr> </table>	AWS	A 5.14: ERNiCu-7	EN ISO	18274: S Ni 4060(NiCu30Mn3Ti)	F-nr	42	FM	6	W.Nr.	2.4377				
AWS	A 5.14: ERNiCu-7														
EN ISO	18274: S Ni 4060(NiCu30Mn3Ti)														
F-nr	42														
FM	6														
W.Nr.	2.4377														
SUITABLE FOR	<p><b>E Ni 4060 (NiCu30Mn3Ti)</b>            2.4360, 2.4361, 2.4365, 2.4375, ( 2.0872, 2.0882, 2.0890 )            NiCu30Fe, NiCu30Al, G-NiCu 30 Nb, LC-NiCu 30 Fe,  <b>ASTM B127, B163, B164, B165</b>  <b>UNS N04400</b>            Monel 400, Monel R405, Monel K-500            Alloy K500 and dissimilar welding between these Alloys.</p>														
APPROVALS	No Approvals Found														
WELDING POSITIONS															
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
C	Si	Mn	Ni	Ti	Cu	Al									
0.09	1	3.5	65	2	30	1									
ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th>R<sub>P0,2</sub></th> <th>R<sub>m</sub></th> <th>A<sub>5</sub></th> <th rowspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>MPa</th> <th>MPa</th> <th>(%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>300</td> <td>450</td> <td>30</td> <td>70</td> </tr> </tbody> </table>	Heat Treatment	R <sub>P0,2</sub>	R <sub>m</sub>	A <sub>5</sub>	Impact Energy (J) ISO-V	MPa	MPa	(%)	As Welded /	300	450	30	70	
Heat Treatment	R <sub>P0,2</sub>		R <sub>m</sub>	A <sub>5</sub>	Impact Energy (J) ISO-V										
	MPa	MPa	(%)												
As Welded /	300	450	30	70											
REDRYING TEMPERATURE	Not required														
GAS ACCORDING EN 14175	I1														



# CEWELD NiCu30Mn

## NICU30MN 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663417954
D-100	1	8720663417947

## NICU30MN 0,9MM

Type	KG/unit	EANCode
BS-300	15	8720663417961

## NICU30MN 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663417978

## NICU30MN 1,2MM

Type	KG/unit	EANCode
BS-300	13,6	8720663417992
BS-300	15	8720663417985

## NICU30MN 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663418005
BS-300	13,6	8720663418012