

# CEWELD CuNi30Fe

**TYPE** Copper-Nickel alloyed Mig / Tig welding wire.

**APPLICATIONS** This Copper-Nickel weld metal is widely used for marine and desalination applications. Dissimilar-welding applications for this alloy are joints between Monel alloys or Nickel 200 and Copper-Nickel alloys. Often used for surfacing on steel by using Ceweld NiTi-3 as a barrier layer. Shipbuilding, seawater evaporation plants, tubes, pump building, offshore, desalting equipment and parts etc.

**PROPERTIES** Sound, pore free deposits on ferrous and non-ferrous base materials offering excellent resistance to corrosion in sea water.

**CLASSIFICATION**

|        |                                |
|--------|--------------------------------|
| AWS    | A 5.7: ERCuNi                  |
| EN ISO | 24373: Cu 7158 / CuNi30Mn1FeTi |
| F-nr   | 34                             |
| W.Nr.  | 2.0837                         |

**SUITABLE FOR** (Monel 67): Wrought and cast alloys of 70-30, 80-20 and 90-10 copper nickel alloys, Monel 450, (alloy 450), Nickel 200, CuNi10Fe, CuNi20Fe (2.0878), CuNi30Fe (2.0882), 2.0872 - CuNi 10 Fe 1 Mn (CuNi 10 Fe),

**APPROVALS** No Approvals Found

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

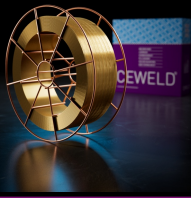
| Si  | Mn  | P    | Ti   | Fe   | Pb   | Cu+Ag | Ni+Co | S    |
|-----|-----|------|------|------|------|-------|-------|------|
| 0.2 | 0.5 | 0.01 | 0.35 | 0.55 | 0.01 | Rem.  | 30.5  | 0.01 |

**ALL WELD MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0,2</sub> MPa | R <sub>m</sub> MPa | A <sub>5</sub> (%) | Impact Energy (J) ISO-V RT | Hardness Brinell Hardness |
|----------------|-----------------------|--------------------|--------------------|----------------------------|---------------------------|
| As Welded /    | 200                   | 420                | 36                 | 200                        | Avg. 115                  |

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175** I1, I3



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## CUNI30FE 0,8MM

| Type   | KG/unit | EANCode       |
|--------|---------|---------------|
| BS-300 | 15      | 8720663409522 |
| D-100  | 1       | 8720663409539 |

## CUNI30FE 1,0MM

| Type   | KG/unit | EANCode       |
|--------|---------|---------------|
| BS-300 | 15      | 8720663409546 |

## CUNI30FE 1,2MM

| Type   | KG/unit | EANCode       |
|--------|---------|---------------|
| BS-300 | 13,6    | 8720663409560 |
| BS-300 | 15      | 8720663409553 |

## CUNI30FE 1,6MM

| Type   | KG/unit | EANCode       |
|--------|---------|---------------|
| BS-300 | 15      | 8720663409577 |

## CUNI30FE 2,4MM

| Type  | KG/unit | EANCode       |
|-------|---------|---------------|
| K-415 | 25      | 8720663409638 |