



CEWELD NiCu30Mn Tig

TYPE Solid Nickel based filler metal alloyed with Copper for TIG welding.

ANWENDUNGEN Shipbuilding, seawater evaporation plants, tubes, pump building, offshore etc.

EIGENSCHAFTEN CEWELD® NiCu30Mn is a Nickel - Copper weld metal and 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 than the base metal.

KLASSIFIKATION

| | |
|--------|-------------------------------|
| AWS | A 5.14: ERNiCu-7 |
| EN ISO | 18274: S Ni 4060(NiCu30Mn3Ti) |
| W.Nr. | 2.4377 |
| F-nr | 42 |
| FM | 6 |

GEEIGNET FÜR

E Ni 4060 (NiCu30Mn3Ti)
 2.4360, 2.4361, 2.4365, 2.4375, (2.0872, 2.0882, 2.0890)
 NiCu30Fe, NiCu30Al, G-NiCu 30 Nb, LC-NiCu 30 Fe,
ASTM B127, B163, B164, B165
UNS N04400
 Monel 400, Monel R405, Monel K-500
 Alloy K500 and dissimilar welding between these Alloys.

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | Ni | Ti | Fe | Cu | Al |
|-----|----|----|----|-----|----|----|-----|
| 0.1 | 1 | 3 | 65 | 2.5 | 2 | 30 | 0.9 |

MECHANISCHE GÜTEWERTE

| Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | RT | | |
| As Welded | 315 | 500 | 32 | 100 | | HRc |

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 I1



CEWELD NiCu30Mn Tig

| | | | |
|---------------------------|-----------|---------|---------------|
| NICU30MN TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663418036 |
| NICU30MN TIG 1,6 X 914MM | Packaging | KG/unit | EanCode |
| | Tube | 4,54 | 8720663418029 |
| NICU30MN TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663418043 |
| NICU30MN TIG 2,0 X 914MM | Packaging | KG/unit | EanCode |
| | Tube | 4,54 | 8720663417664 |
| NICU30MN TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663418050 |
| NICU30MN TIG 2,4 X 914MM | Packaging | KG/unit | EanCode |
| | Tube | 4,54 | 8720663418067 |
| NICU30MN TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663418074 |
| NICU30MN TIG 3,2 X 914MM | Packaging | KG/unit | EanCode |
| | Tube | 4,54 | 8720663418081 |