



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 than the base metal.

CLASSIFICATION

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

SUITABLE FOR

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.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

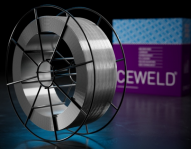
C	Si	Mn	Ni	Ti	Cu	Al
0.09	1	3.5	65	2	30	1

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	300	450	30	70	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD NiCu30Mn

NICU30MN 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417954
D-100	1	8720663417947

NICU30MN 0,9MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417961

NICU30MN 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417978

NICU30MN 1,2MM

Packaging	KG/unit	EanCode
BS-300	13,6	8720663417992
BS-300	15	8720663417985

NICU30MN 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663418005
BS-300	13,6	8720663418012