

Cu-base solid wire

Classification

AWS A5.7-8R :ERCuNi
EN 14640 :S Cu 7158 (CuNi30)

General Description

Solid wire for welding copper-nickel alloys containing 10-30%Ni

Shielding gas (acc. EN)

GTAW/GMA I1 Inert gas Ar 100%
W
I3 Inert gas Ar + > 0-95% He

Approvals

TÜV

GTAW +

Chemical composition (w%), typical, all weld metal

Cu	Mn	Ni
rest	0.8	31

Mechanical properties, all weld metal

	Process	Shielding gas	Condition	0.2% Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact (ISO), J +20 °C	Hardness HB
Typical values	GTAW	I1	AW	250	400	30	100	70
after welding	GMAW	I1	AW	220	380	30		70

Materials to be welded

Material grades such as:	Code	Type	W.Nr.	UNS
Cu-Ni wrought alloys	DIN 17664	CuNi10Fe1Mn	2.0872	C70600
		CuNi30Mn1Fe	2.0882	C71500
		CuNi30Fe2Mn2	2.0883	C71600
Cu-Ni cast alloys	DIN 17658	G-CuNi10	2.0815	
		G-CuNi30	2.0835	

Packaging, available sizes and identification

Process	Unit:	Sizes, mm					
		0.8	1.2	1.6	2.0	2.4	3.2
GTAW	2kg tube			X	X	X	X
GMAW	12 kg spool B300	X	X				

Other sizes and packaging on request

Identification

Imprint: Nichrofer®C-4

Tip colour:

Nichrofer®C-4 : rev.EN 20