CEWELD NiCu30Mn Tig

certilas® THE FILLER METAL SPECIALIST

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 then 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

TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)

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)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	315	500	32	100	HRc

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

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