



# CEWELD NiCu30Mn

**TYPE** Mig-Mag welding wire for Monel 400

**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** 2.4360, 2.4375, NiCu30Fe, NiCu30Al, Monel 400, R405, alloy K500 and dissimilar welding between these alloys.

**APPROVALS**

**WELDING POSITIONS**



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

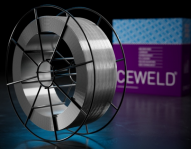
C	Si	Mn	Ni	Ti	Cu	Al
0.09	1	3.5	65	2	30	1

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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