



# SUPER CuNi

NON FERROUS (Ni Alloys)

AWS A/SFA 5.6 **ECuNi**

### CLASSIFICATION:

ISO 17777

E Cu 7158 (CuNi30Mn2FeTi)

### KEY FEATURES:

- Typical 70Cu-30Ni type weld deposit
- Easy slag removal
- Shiny and uniform bead
- Crack resistant weld
- No preheating required
- Weld deposit resistant to sea water

**APPROVALS:** CE

### TYPICAL APPLICATIONS:

- Welding of wrought and cast 70/30, 80/20, 90/10 Copper-Nickel alloys to themselves or to each other
- Welding of Copper-Nickel alloys of up to 30% Ni
- Clad side of copper-nickel clad steels
- Surfacing applications where high resistance to corrosion, erosion or cavitation is required
- Ship building, food industries, desalination plants, refrigerators, heat exchangers

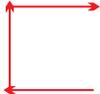
### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

Mn	Si	Fe	Ni	Cu
1.7	0.3	0.65	31.5	68.5

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Hardness, HBS
Specification	As Welded	350 min	20 min	60-80

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	60-80	 <b>DCEP</b> All Positions, except vertical Down  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr
3.15 x 350	90-100	
4.0 x 350	110-130	

Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.