

TIGWELD NiCu30Mn

TIG Rods [GTAW]

Nickel alloys

CLASSIFICATION: EN ISO 18274-A : S Ni4060 AWS A-5.14 : ER NiCu-7	APPROVALS:	APPLICATION: Petrochemical and chemical industry Shipbuilding&Offshore
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- TIG welding rod based on nickel with the addition of copper.
- Good corrosion resistance in many media such as sea water, salts, acids.
- Can be age hardened.

Application

Shipbuilding, sea water evaporation plants, pipes and other marine installations.

Typical chemical composition %

C	Si	Mn	Ni	Cu	Al	Ti
0,09	1,00	3,50	65,00	rest	1,00	2,00

Typical mechanical properties

Yield strength Re [N/mm²]	>300
Tensile strength Rm [N/mm²]	>450
Elongation A5 [%]	>30
Impact energy Kv [J]	>80J (20°C) /

Welding positions



Shielding gases acc. to EN ISO 14175 | I1 - Ar /

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]
2,0	1000 /	70-110	5,0
2,4	1000 /	110-180	5,0

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