

## MIG/MAG solid wires-TIG rods Nickel and Copper alloys

NIFIL NiCu7 is an S Ni 4060 / ER NiCu-7 type solid MIG welding wire, supplied precision layer wound, depositing 65Ni-30Cu3Mn2Ti (Monel-type) weld metal. Suitable for use with inert shielding gases.

NIFIL NiCu7 is used for welding of similar alloys such as 70Ni-30Cu (Monel). Suitable for joining and surfacing also on unalloyed / low alloy steels and cast steels. The weld metal has a high corrosion resistance in saline solution and sea water. Typical applications are in the chemical industry, food processing plant and seawater desalination plants.

NIFIL NiCu7 contains sufficient titanium to control weld metal porosity and for grain refinement.

### Classification

EN ISO	18274: S Ni 4060 (NiCu30Mn3Ti)
AWS	A5.14: ER NiCu7

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Cu	Fe
0.10	3	1	≤ 0.02	≤ 0.015	Rest	30	1

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
As Welded	≥ 350	≥ 480	≥ 30	≥ 150

Gas test: ArHeH+C 30/2/0.12

**Shielding Gas** - EN ISO 14175 : I1, I3

### Materials

2.4360 (NiCu30Fe); 2.4375 (NiCu30Al); 2.4377

UNS N04400; UNS N 05500

### Storage

Keep dry and avoid condensation.

### Current condition and welding position

DC+



### Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
1.0	●
1.2	●