

NIROD NiCu7 is an S Ni 4060 / ER NiCu-7 type solid TIG welding rod depositing 65Ni-30Cu3Mn2Ti (Monel-type) weld metal. Suitable for use with inert shielding gases.

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

NIROD NiCu7 contains sufficient titanium to control weld metal porosity and to promote grain refinement.

Classification

EN ISO	18274: S Ni 4060 (NiCu30MnTi)
AWS	A5.14: ER NiCu 7

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Cu	Fe
0.1	3	1	≤ 0.020	≤ 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: 100% Ar

Shielding Gas - EN ISO 14175 : I1

Materials

2.4360 (NiCu30Fe); 2.4375 (NiCu30Al)

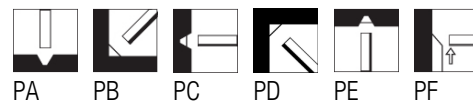
UNS N04400; UNS N 05500

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
2.0	TUB	5	●
2.4	TUB	5	●