

CUPRONIC 70 is a basic-coated MMA electrode for alloy types CuNi 70-30 or CuNi 90-10. Suitable for joining and surfacing, the weld metal has an excellent resistance to salt water corrosion. Typical applications are in the shipbuilding, offshore oil and chemical industries and for seawater desalination plant.

Classification

AWS A5.6: E CuNi

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Cu	Fe	Ti	Pb
0.01	1.4	0.02	≤ 0.02	≤ 0.01	29.5	Rem	0.5	≤ 0.5	≤ 0.02

All-weld metal Mechanical Properties

Heat Treatment	Tensile Strength (MPa)	Elongation A5 (%)
As Welded	≥ 350	≥ 20

Materials

2.0872 (CuNi10Fe1Mn9); 2.0882 (CuNi30Mn1Fe)

UNS C70600; UNS C71500

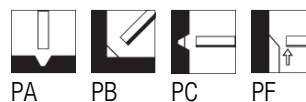
Storage

Keep dry and avoid condensation.

Re-dry at 280-300 °C for 1 hour, 5 times max.

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	VPMD	
				PC	Code
2.5	300	50-70	16.4	100	●
3.2	350	75-100	31.6	60	●
4.0	350	90-130	48.0	40	●