

ER NiCu-7 (Monel 400)

Nickel Alloy TIG/GTAW

Standards

EN/ISO-Standard - 18274

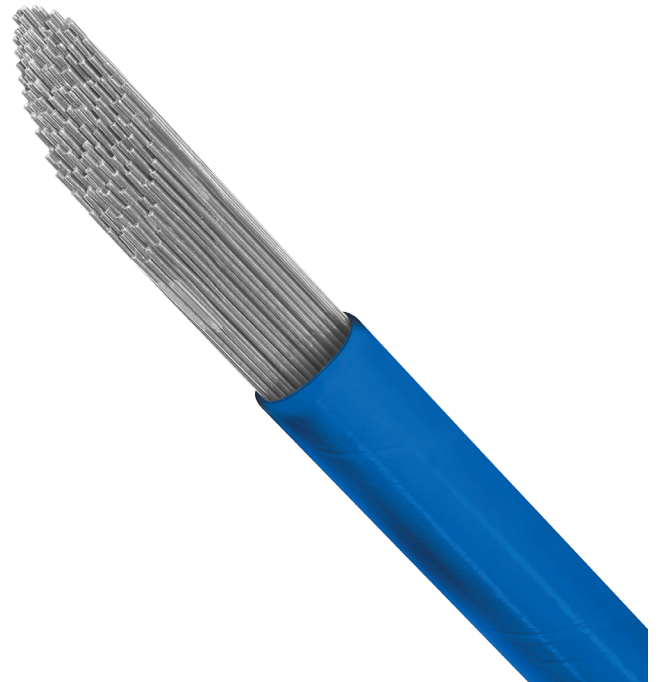
AWS-Standard - A5.14

EN/ISO-Classification - Ni 4060 - NiCu30Mn3Ti

AWS-Classification - ER NiCu-7

Features and Applications

- Nickel-copper alloy designed for welding Monel.
- Good bead appearance and excellent corrosion resistance in saline solutions.
- The weld metal has an excellent resistance to a large amount of corrosive media's.
- This alloy is also used for weld overlay.
- Typically used in marine construction, especially offshore, heat exchangers, pipelines, desalination plants, chemical, petrochemical and energy engineering industries etc.
- **Test Certificates can be found online @wilkinsonstar247.com**



Typical Base Materials

Monel alloys 400 and 404*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

TIG DC (-)

Mechanical Properties

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)
≥450	≥180	≥30	≥80

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition of Weld Metal %

C %	Mn %	Fe %	P %	S %	Si %	Cu %	Ni %	Co %	Ti %	Al %	Nb + Ta %
max	3.00	0.50	max	max	max	28.00	62.00	max	1.50	max	max
0.15	4.00	2.50	0.020	0.015	1.00	32.00	69.00	1.0	3.00	1.00	0.50

Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
6011100605	1.60	1000	5	Cardboard Tube
6011100606	2.40	1000	5	Cardboard Tube
6011100607	3.20	1000	5	Cardboard Tube

Liability: Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.



TDS.ERNiCu-7.GTAW_rev1