

# LNT/LNM CuNi30

## Cu-base solid wire

### Classification

AWS A5.7-84R : ERCuNi  
DIN 1733-88 : SG-CuNi30Fe

### General description

Solid wire for welding copper-nickel alloys containing 10-30%Ni

### Shielding gases (acc. EN 439)

GTAW/GMAW I1 Inert gas Ar (100%)  
I3 Inert gas Ar+ >0-95% He

### Approvals

TÜV  
GTAW +

### Chemical composition (w%), typical, wire / rod

Cu	Mn	Ni
bal.	0.8	31

### Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) +20°C	Hardness HB
Typical values	GTAW	I1	AW	250	400	30	100	70
	GMAW	I1	AW	220	380	30		70

### Materials to be welded

Material	Code	Type	W.Nr.	UNS
Copper-nickel wrought alloys	DIN 17664	CuNi10Fe1Mn	2.0872	C 70600
		CuNi30Mn1Fe	2.0882	C 71500
		CuNi30Fe2Mn2	2.0883	C 71600
Copper-nickel cast alloys	DIN 17658	G-CuNi10	2.0815	
		G-CuNi30	2.0835	

### Packaging

Process	Unit	Sizes (mm)						
		0.8	1.2	1.6	2.0	2.4	3.2	
GTAW	2 kg tube			X	X	X	X	
GMAW	12 kg spool B300	X	X					

Other sizes and packaging on request

LNT/LNM CuNi30: rev. EN 15