

LNT/LNM NiCu 70/30

Ni-base solid wire

Classification

AWS A5.14/A5.14M-97 : ERNiCu-7
ISO 18274-01 : S Ni 4060 (NiCu30MnTi)

General description

Solid wire for welding Monel and NiCu-alloys to mild and low-alloyed steels
High resistance to seawater corrosion

Shielding gases (acc. EN 439)

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

Approvals

	TÜV
GTAW	+
GMAW	+

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

C	Mn	Si	Ni	Cu	Fe	Ti
0.10	3.3	0.6	64	29	1.5	2.4

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
							+20°C	-196°C
Typical values	GTAW	I1	AW	350	550	40	160	140
	GMAW	I1	AW	300	500	35	150	

Materials to be welded

Steel grades	BS3076	DIN 17743	W.Nr.	ASTM/ACI	UNS
	NA 13	NiCu30Fe	2.4360	Monel 400	N04400
		G-NiCu30Nb	2.4365		
	NA 18	NiCu30Al	2.4375	Monel K500	N05500

Packaging

Process	Unit	Sizes (mm)						
		1.0	1.2	1.6	2.0	2.4	3.2	
GTAW	2 and 10 kg tube				X	X	X	X
GMAW	15 kg spool BS300	X	X					

Other sizes and packaging on request

LNT/LNM NiCu 70/30: rev. EN 15