

## Cu-base solid wire

### Classification

AWS A5.7-84R	: ERCuNi
EN14640	: S Cu 7158 (CuNi30)

### 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 type	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 and available sizes

Process	Unit	Diameter (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 20

**Liability:** All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request