

# LNT/LNM NiCu 70/30

## Ni-base solid wire

### Classification

AWS A5.14/A5.14M : ERNiCu-7  
ISO 18274 : 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 <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	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

Material type	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 and available sizes

Process	Unit	Diameter (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 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