

ROYAL ER NiCu7 (ER NiCu7)

AWS –SFA A 5.14 ER NiCu7 EN ISO 18274 S Ni 4060

Applications

Nickel –copper alloys ASME B-127 B- 163, B-164 & B-165 UNS No. 4400 with gas tungsten arc, gas metal arc, submerged arc and plasma arc welding process. The filler metal contain titanium to control porosity with these processes.

Characteristics on Usage

This type of filler wire contain 65% Ni, 30% Cu, 3% Mn and 2%Ti gives excellent welding performance and used for welding of f Nickel- copper alloys

Packing

Each Packets content 5 kg of Wire Rods having length 500 mm.,1000mm.

MIG TIG WIRES

Chemical Composition Of Weld Metal

| C% | Mn% | Si% | S% | P% | Ni % | Al | Cu % |
|----------|---------|----------|-----------|-----------|-------------|----------|------|
| 0.15 Max | 4.0 Max | 1.25 Max | 0.015 Max | 0.020 Max | 62.0 - 69.0 | 1.25 Max | Rem. |

Mechanical Properties Of Weld Metal

U.T.S.
(N/mm²)

480 Min