

LNМ CuNi30

CLASSIFICATION

AWS A5.7	ERCuNi	A-Nr	-	Mat-Nr	2.0837
EN 14640	S Cu 7158 (CuNi30)	F-Nr	34		
		9606 FM	-		

GENERAL DESCRIPTION

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

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

SHIELDING GASES (ACC. ISO 14175)

I1	Inert gas Ar (100%)
I3	Inert gas Ar+ 0.5-95% He

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

Cu	Ni	Mn
bal.	31	0.8

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Hardness HB
Typical values	I1	AW	220	380	30	70

EXAMPLES OF MATERIALS TO BE WELDED

Cu-alloy grades	Standard	Type	Mat. 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

Diameter [mm]	1.2
15 kg spool BS300	X
Other sizes and packaging on request	

LNМ CuNi30: rev. C-EN25-01/02/16