

65NiCu

TIG (GTAW)

SOLID ROD FOR TIG TO MATCH MONEL ALLOYS

PRODUCT DESCRIPTION

Solid rod for TIG

CLASSIFICATIONS

AWS A5.14M ERNiCu-7
 ISO 18274 S Ni 4060
 Also known generically as filler metal 60 (FM60)

ASME IX QUALIFICATION

QW432 F-No 42

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Ni	Cu	Ti	Fe	Al
Min.	--	3.0	--	--	--	62.0	28.0	1.5	--	--
Max.	0.15	4.0	1.2	0.015	0.020	69.0	32.0	3.0	2.5	1.2
Typical	0.03	3.2	0.2	0.005	0.005	64	29	2.2	<1	0.1

ALL-WELD MECHANICAL PROPERTIES

As welded	Min.	Typical
Tensile strength (MPa)	460	525
0.2% proof strength (MPa)	200	280
Elongation (%) 4d	--	41
5d	25	38
Impact ISO-V(U) -30°C	--	120

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon*	DC-	2.4	100A, 12V

* Ar + 1-5%H₂ also suitable.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	2.5	PE TUBE	T65NICU-16
2.4	2.5	PE TUBE	T65NICU-24