

LNM NiCu 70/30

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 alloy steels
Can be used as well for welding mild and low alloy steels to NiCu alloys
High resistance to seawater corrosion

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

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cu	Fe	Ti
0.1	3.3	0.6	64	29	1.5	2.4

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						+20°C	-196°C
Typical values	I1	AW	300	500	35	150	60

EXAMPLES OF MATERIALS TO BE WELDED

Ni-alloy grades		DIN 17743	Mat. Nr	ASTM/ACI	UNS
BS3076	NA 13	NiCu30Fe	2.4360	Monel 400	N04400
		G-NiCu30Nb	2.4365		
	NA 18	NiCu30Al	2.4375	Monel K500	N05500

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.2
Unit :	15 kg spool BS300 X
Other sizes and packaging on request	

LNM NiCu 70/30: rev. EN 23