



### Characteristics and scope of application

- Filler metal for NiCu Alloys, excellent corrosion resistance in seawater environments
- Application in desalination plants and chemical process industry
- Recommended for dissimilar welds of NiCu alloys and mild steels

### Standard designations

DIN EN ISO 18274	AWS A5.14	DIN Mat.-No.
S Ni 4060 (NiCu30Mn3Ti)	ERNiCu-7	2.4377

### Typical chemical composition of filler metal

	C	Si	Mn	Cu	Ni	Ti
Mass %	0.02	0.3	3.3	29	Bal.	2.3

### All weld metal properties (min. values at rt)

Heat treatment	Yield strength	Tensile strength	Elongation	Impact toughness	
	Rp0.2	R <sub>m</sub>	A <sub>5</sub>	ISO-V	
as welded	44 ksi	65 ksi	30%	120 J	

### Welding instructions

Polarity	Shielding gas acc. to AWS A5.32
DC / +	SG-A, SG-AHe, SG-A-G (He 30% - H 2% - C ~0.1)
DC / -	SG-A, SG-AHe, SG-AH (max. 5% H <sub>2</sub> DC / -)

Low heat input and interpass temperature < 248°F. Stringer bead technique recommended.

#### Base materials

2.4360 – NiCu30Fe – Alloy 400

2.4375 – NiCu30Al – Alloy K 500

### Packaging (tolerances acc. to AWS A5.02)

Approvals on request

Diameter (in)		lbs/PU
1/16 - 1/8	X 36 in	11 / 22
0.035 – 0.045	BS 300 spool	33
0.06 – 1/8	K 415 / K 435 spool	55