

Standards

TS EN ISO 18274	: S Ni 4060 (NiCu 30 Mn 3 Ti)
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AWS A5.14	: ER NiCu 7

**Chemical Composition of
Welding Wire % (Typical)**

Al	Si	Cu	C	Ni	Mn	Fe	Ti
1.25	1.25	Rest	0.15	65	3.5	2.5	2.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
300	500	120 J	35

Typical Base Material Grades

- NiCu 30 Fe (2.4360) - NiCu 30 Al (2.4375) - UNS N04400, N05500 - Alloy 400 ASTM B 127, B 165, MONEL400, MONEL 405, 2.4377

Features and Applications

- It is used for welding of Nickel Copper alloys to steels and copper alloys to steel, gray iron to steels and stainless steels
- Weld metal has perfect stainless properties, used in sea water applications, chemical and petrochemical industry and ship equipments
- Shielding Gas: MIG: Argon /TIG: Argon

Welding Positions

Current Type

MIG D.C. (+) / TIG D.C.(-)

Operating Data

Product Code	Diameter x Length (mm) / (inch)	Welding Current (A)	Package Weight (Kg)
6031100305	1.00	0,040"	15
6031100306	1.20	0,047"	15
6031100307	2,4 x 1000	3/32 x 39"	5

Approvals: SEPRO