



# CEWELD NiCu30Mn Tig

**TYPE** GTAW welding wire for Monel 400 and similar alloys.

**APPLICATIONS** Shipbuilding, seawater evaporation plants, tubes, pump building, offshore etc.

**PROPERTIES** CEWELD® NiCu30Mn is a Nickel - Copper weld metal and has properties similar to "Monel 400". It has good strength and resists corrosion in many media, including sea water, salts and reducing acids. The weld metal is not age hardenable and when used to join Monel K-500 it has lower strength than the base metal.

**CLASSIFICATION**

|        |                               |
|--------|-------------------------------|
| AWS    | A 5.14: ERNiCu-7              |
| EN ISO | 18274: S Ni 4060(NiCu30Mn3Ti) |
| W.Nr.  | 2.4377                        |
| F-nr   | 42                            |
| FM     | 6                             |

**SUITABLE FOR**

**E Ni 4060 (NiCu30Mn3Ti)**  
 2.4360, 2.4361, 2.4365, 2.4375, ( 2.0872, 2.0882, 2.0890 )  
 NiCu30Fe, NiCu30Al, G-NiCu 30 Nb, LC-NiCu 30 Fe,  
**ASTM B127, B163, B164, B165**  
**UNS N04400**  
 Monel 400, Monel R405, Monel K-500  
 Alloy K500 and dissimilar welding between these Alloys.

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

| C   | Si | Mn | Ni | Ti  | Fe | Cu | Al  |
|-----|----|----|----|-----|----|----|-----|
| 0.1 | 1  | 3  | 65 | 2.5 | 2  | 30 | 0.9 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>p0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|----------|
|                |                         |                      |                    | RT                      |          |
| As Welded      | 315                     | 500                  | 32                 | 100                     | HRc      |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD NiCu30Mn Tig

|                           |           |         |               |
|---------------------------|-----------|---------|---------------|
| NICU30MN TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode       |
|                           | Tube      | 5       | 8720663418036 |
| NICU30MN TIG 1,6 X 914MM  | Packaging | KG/unit | EanCode       |
|                           | Tube      | 4,54    | 8720663418029 |
| NICU30MN TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                           | Tube      | 5       | 8720663418043 |
| NICU30MN TIG 2,0 X 914MM  | Packaging | KG/unit | EanCode       |
|                           | Tube      | 4,54    | 8720663417664 |
| NICU30MN TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode       |
|                           | Tube      | 5       | 8720663418050 |
| NICU30MN TIG 2,4 X 914MM  | Packaging | KG/unit | EanCode       |
|                           | Tube      | 4,54    | 8720663418067 |
| NICU30MN TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                           | Tube      | 5       | 8720663418074 |
| NICU30MN TIG 3,2 X 914MM  | Packaging | KG/unit | EanCode       |
|                           | Tube      | 4,54    | 8720663418081 |