



# 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