



# CEWELD CuNi10Fe

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                            |                         |                       |                         |     |     |    |          |       |
|------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|-------------------------|-----------------------|-------------------------|-----|-----|----|----------|-------|
| TYPE                                                 | Fil de soudage MIG en alliage cuivre-nickel                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                            |                         |                       |                         |     |     |    |          |       |
| APPLICATIONS                                         | CEWELD® CuNi10Fe convient au soudage et au rechargement des matériaux CuNi selon la norme EN ISO 17664 et des alliages CuZn résistants à l'eau de mer selon la norme EN ISO 17660. Il convient également au surfacage des aciers faiblement alliés et non alliés et des fontes grises.                                                                                                                                                                                                                                                                                                                           |                            |                         |                       |                         |     |     |    |          |       |
| PROPRIÉTÉS                                           | Résistant à l'eau de mer                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                            |                         |                       |                         |     |     |    |          |       |
| CLASSIFICATION                                       | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 24373: Cu 7061 / CuNi10    |                         |                       |                         |     |     |    |          |       |
|                                                      | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 2.0873                     |                         |                       |                         |     |     |    |          |       |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 37                         |                         |                       |                         |     |     |    |          |       |
| CONVIENT POUR                                        | CuNi5Fe (2.0862), CuNi10Fe1Mn (2.0872)<br>Cunifer 10, Cuni10fe, seawater resistant, marine applications, tubes, pump building, offshore etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                            |                         |                       |                         |     |     |    |          |       |
| AGRÉMENTS                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                            |                         |                       |                         |     |     |    |          |       |
| POSITIONS DE SOUDAGE                                 | <div>PAPBPCPDPEPFPG</div> |                            |                         |                       |                         |     |     |    |          |       |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Si                         | Mn                      | P                     | S                       | Ti  | Fe  | Cu | Pb       | Ni+Co |
|                                                      | 0.02                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 0.1                        | 1                       | 0.01                  | 0.01                    | 0.4 | 1.5 | 89 | 0.01     | 10    |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V |     |     |    | Hardness |       |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                            | 300                     | 34                    | RT                      |     |     |    | 80 HB    |       |
| ETUVAGE                                              | Non requis                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                            |                         |                       |                         |     |     |    |          |       |
| GAS ACC. EN ISO 14175                                | I1, I3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                            |                         |                       |                         |     |     |    |          |       |



# CEWELD CuNi10Fe

## CUNI10FE 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663409447 |
| D-100     | 1       | 8720663409454 |

## CUNI10FE 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663409461 |

## CUNI10FE 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663409478 |