

GM 812



Solid Wire For MIG Welding

IDENTIFICATION : ERCuNi

SPECIFICATION : AWS/SFA 5.7: ERCuNi, BS 2901 :Pt 3, Grade C 18, DIN 1733:SG-CuNi30Fe

CHARACTERISTICS :

Copper -nickel solid wire depositing 70Cu-30Ni weld metal .This wire is used for welding similar cupronickel alloys and Cupro-Nickel type 90% Copper 10% Nickel. The weld metal is resistant to sea-water, corrosion.

TYPICAL APPLICATION :

For-off-shore pipe and cladding systems, desalination plants, condensers and evaporators, heat exchangers, etc. Materials to be welded: BS: 70CuNi CN103-CN107, ASTM/ASME: CA715/UNS C71500, CA964/UNS C96400, OTHERS: Kunifer 30(IMI), Cunifer 30& 302(VDM). Also suitable for welding 90/10 cupronickels below:

- 90CuNi CN101 CA 706/UNS C70600 Kunifer 0(IMI)
- CN102 CA 962/UNS C96200 Cunifer 10(VDM)

CHEMICAL COMPOSITION OF THE WIRE % :

Ni	Si	Mn	Pb	Ti	P	S	Fe	Cu
30.0-32.0	0.20 max	0.5-1.0	0.007 max	0.20-0.50	0.01 max	0.01 max	0.40-0.75.	Remainder (balance)

ALL WELD MECHANICAL PROPERTIES (TYPICAL) :

Ult. Tensile Strength N/mm ²	0.2% Proof Stress N/mm ²	Elongation % (L=4D)	Hardness HV
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345-430	180-250	40	105
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SHIELDING GAS : Pure Argon (99.99%)

RECOMMENDED CURRENT AND PACKING DATA :

Size (mm)	WEIGHT PER SPOOL IN KG
0.80	12.50
1.0	12.50
1.2	12.50