

# TIG Ni60



## Classification

EN 18274 : S-NiCu30Mn3Ti  
AWS A5.14 : ERNiCu-7

Material.N°: 2.4377

## Description & Applications

Solid rod used to weld components for chemical and petrochemical installations, for sea water and off shore applications.

Base Materials: Alloy 400, UNS N04400, NiCu30Fe as well as Copper-Nickel alloys to carbon steels.

## Typical Chemical Composition ( % )

C	Si	Mn	Fe	Ti	Cu	P	S	Ni
0.03	0.4	3.5	0.6	2.2	29	<0.01	<0.01	Base

## All Weld Metal Mechanical Properties

Rp0.2 ( MPa )	Rm ( MPa )	A5 ( % )	KV ( J )
320	510	38	+ 20° C : 180

## Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon : 3-6 l/min

ind.05



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