



ER NiCu-7 (MONEL 400)

Nickel Alloy WIRE/GTAW

Standards

EN/ISO-Standard - 18274

EN/ISO-Classification - S Ni 4060 - NiCu30Mn3Ti

AWS-Standard - A5.14

AWS-Classification - ER NiCu-7

Features and Applications

- Nickel-copper alloy designed for welding Monel.
- Good bead appearance and excellent corrosion resistance in saline solutions.
- The weld metal has an excellent resistance to a large amount of corrosive media's.
- This alloy is also used for weld overlay.
- Typically used in marine construction, especially offshore, heat exchangers, pipelines, desalination plants, chemical, petrochemical and energy engineering industries etc.
- **Test Certificates can be found online @wilkinsonstar247.com**



Typical Base Materials

Monel alloys 400 and 404*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

DC (-)

Chemical Composition % (Range)

C %	Mn %	Fe %	P %	S %	Si %	Cu %	Ni %	Co %	Ti %	Al %	Nb + Ta %
max	3.00	0.50	max	max	max	28.00	62.00	max	1.50	max	max
0.15	4.00	2.50	0.020	0.015	1.00	32.00	69.00	1.0	3.00	1.00	0.50

Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
6011100605	1.60	1000	5	Cardboard Tube
6011100606	2.40	1000	5	Cardboard Tube
6011100607	3.20	1000	5	Cardboard Tube

Mechanical Properties

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)
≥450	≥180	≥30	≥80

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.