

OK Tigrod 19.49

GTAW
ERCuNi

Description

Bare Cu-Ni rods for welding similar alloys, such as 90Cu10Ni, 80Cu20Ni and 70Cu30Ni alloys. The addition of nickel strengthens the weld metal and improves corrosion resistance, particularly to salt water. The alloy is used for the overlay welding of steels and is widely used for welding Cu-Ni components for desalination plants.

Welding current

DC(-)

Classifications

SFA/AWS A5.7	ERCuNi
EN 14640	S Cu 7158 (CuNi30)

Wire composition

C	Si	Mn	Fe	Cu
<0.05	<0.1	0.8	0.6	bal.

Typical mech. properties all weld metal

Yield stress, MPa	180
Tensile strength, MPa	350
Elongation, %	40

Charpy V

Test temps, °C	Impact values, J
+20	90

Packing data

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5
2.0	1000	5
2.4	1000	5