

MIDALLOY ERCuNi (FM67) BARE WIRE

CLASSIFICATION

- AWS 5.7 Class ERCuNi / ASME SFA 5.7 Class ERCuNi

DESCRIPTION

- MIDALLOY ERCuNi copper-nickel alloy bare wire is used for GMAW, GTAW, and SAW welding.

APPLICATIONS

- MIDALLOY ERCuNi is used for joining base materials such as UNS number C71500. This includes ASTM grades such as B111, B122, B151, B171, B359, B395, B432, B466, B467, B543, and B552.
- This alloy can be used for dissimilar welding applications welding various copper-nickel alloys to nickel alloys and various other copper-nickel alloys.
- MIDALLOY ERCuNi is occasionally used for overlay on carbon steel, but can only be used after applying a layer of ERNi-1 first.

TYPICAL CHEMISTRY

Cu + Ag	Mn	Fe	Si	Ni + Co	P	Pb	Ti
68.44	.75	.48	.02	29.9	.002	PPM<100	.39

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	52,500 PSI
YIELD STRENGTH	21,000 PSI
ELONGATION	32%

RECOMMENDED WELDING PARAMETERS

- (See Attached)

STANDARD PACKAGING

- TIG 10 lb. tube / 60 lb. carton
- MIG 30 lb. spool
- SUB-ARC 60 lb. coil

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