

MIDALLOY ERNiCu-7 (FM60) BARE WIRE

CLASSIFICATION

- AWS 5.14 Class ERNiCu-7 / ASME SFA 5.14 Class ERNiCu-7

DESCRIPTION

- MIDALLOY ERNiCu-7 nickel-copper alloy bare wire is used for GMAW, GTAW, and SAW welding.

APPLICATIONS

- MIDALLOY ERNiCu-7 is used for joining base materials such as UNS number N04400, number N04405, and number N05500. This includes ASTM grades such as B127, B163, B164, B165, and B564.
This alloy can also be used for dissimilar welding applications using various nickel-copper alloys to nickel 200 and to copper-nickel alloys.
This alloy can be used to overlay over carbon steel, provided a buffer layer of ERNi-1 is used for the first layer.

TYPICAL CHEMISTRY

Table with 10 columns: C, Mn, Fe, P, S, Si, Cu, Ni, Al, Ti. Values: .05, 3.53, .53, .004, .002, .87, Bal., 65.3, .02, 2.20

TYPICAL MECHANICAL PROPERTIES

Table with 2 columns: Property, Value. Rows: TENSILE STRENGTH (75,000 PSI), YIELD STRENGTH (52,000 PSI), ELONGATION (34%)

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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