

TECHNICAL DATA

Specification

Material Number.: 2.4377 / S Ni 4060 (NiCu30Mn3Ti) / ER NiCu-7

Filler rod/filler wire of nickel-copper-alloy for joint welding and overlay of nickel-copper alloys and claddings of similar composition for operating temperatures up to +425 °C; tough at sub-zero down to -196°C.

Field of Applications

The cleanliness of the workpiece in the weld seam area is a requirement for a crack-free joint. For thin sheets and root welds, lower seam protection is required. With V and X seams, the opening angle must be 70° minimum. Always guide TIG filler rod in shielding gas area. MAG filler wire preferably weld in pulsed arc. At high welding velocities work with gas protection following the torch shroud (argonspray).

Mechanical Properties

Tensile strength Rm (N/mm ²)	500
0.2%-yield strength (Rp0.2)(mpa)	300
Elongation A (L-5d)%	30

Composition in %				
C 0.02	Si 0.20	Mn 3.30	Fe 1.00	Cu 30.00
Ti 2.00	Ni Rest			

Compatible Materials:

Nickel copper alloys, e.g. MONEL400, MONEL500, NiCu30Fe (2.4360), NiCu30Al (2.4375) and joints of steel with nickel-copper- and copper alloys, coatings and buffer layers.

Available Sizes:

MA125 Spools/ Rod 500 mm: Ø mm 0.4 / 0.5 / 0.6 / 0.7 / 0.8

Rods (500 mm): Ø mm 0.4 / 0.5 / 0.6 / 0.7 / 0.8



EN 10204/3.1 2005 Quality Certified



e-version