

TECHNICAL DATA

Standards

DIN Material Nr.: 2.4377 / Brand Name: Monel

EN ISO 18274 :	S Ni 4060 / NiCu30Mn3Ti
AWS A5.14 :	ERNiCu-7

General Properties / Field of Applications

DSI M NiCu70/30 is a Nickel-copper-alloy Laser Welding Wire for joint and overlay weldings of nickel-copper alloys and claddings of similar composition for operating temperatures up to 425°C tough at sub-zero down to -196°C. The cleanliness of the workpiece Ni the weld seam area is a requirement for a crack-free joint.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	300
Tensile strength R_m	[MPa] / [N/mm ²]	500
Elongation A ($L_0 = 5d_0$)	[%]	35
Notch impact work	[J]	150 at +20°C

Chemical Composition (Standard Values in %)

Ni	C	Cu	Fe	Mn	Si	Ti
Base	0.02	30.0	1.0	3.3	0.2	2.0

Compatible Materials (Selection)

Nickel-copper alloys, e.g. NiCu 30 Fe (2.4360), and joints with copper alloys and steels; joints of copper alloys with steels (black-red joints); cladding and buffer layers.

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

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