

RECORD NiCuW

DESCRIPTION

- Agglomerated flux for SAW and cladding with Soudor NiCu 7.
- Good weldability and high hot cracking resistance.

GENERAL CHARACTERISTICS

- Current / Intensity DC (+ and -) and AC - 800 A max.
- Basicity index 0.6 (according to Boniszewski)
- Granulometry 0.4 - 1.4 mm (14 x 40 Mesh ASTM)
- Apparent density 0.85
- Consumption 0.5 (kg fused flux / kg wire)
- Redrying 1 to 2 hours at 350 +/- 50° C

TYPICAL ANALYSIS OF WIRE AND WIRE/FLUX COMBINATION (%)

	ASME 5.14	DIN 1736	C	Mn	Si	Cu	Fe	Ti	Ni
Soudor NiCu 7	ERNiCu-7	UP-NiCu70MnTi	0.07	3.8	0.4	29	0.15	2.0	bal.
All-weld metal			0.02	3.6	1.3	29	2.50	0.6	bal.

ALL-WELD METAL TYPICAL MECHANICAL PROPERTIES

Wire	Rm[MPa]	Rp0.2[MPa]	A5[%]	Av[ISO - V]
Soudor NiCu 7	490	260	45	100 J : + 20° C

SUITABLE FOR

Alloy	UNS	DIN	W. - Nr.
400	N04400	NiCu30 Fe	2.4360
-	-	LC - NiCu30 Fe	2.4361
-	-	G - NiCu30 Nb	2.4365
K500	N05500	NiCu30 Al	2.4375
-	-	NiCu14 FeMo	2.4400

PACKING

25 kg (pail)