

DESCRIPTION

- Agglomerated flux designed for joining and cladding of NiCu alloys with Soudor NiCu 7.
- Good weldability coupled with an elevated resistance against hot cracking.

GENERAL CHARACTERISTICS

- Current DC (+ and -) and AC – 800 A max
- Basicity index 0.6 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 – 1.4 mm (14 x 40 N° ASTM)
- Apparent density 0.85
- Consumption 0.5 (kg fused flux / kg wire)
- Redrying 1 to 2 hours at 350 +/- 50°C

TYPICAL ALL-WELD METAL ANALYSIS OF WIRE/FLUX COMBINATION (WEIGHT%)

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

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

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

SUITABLE FOR

Alloy	UNS	DIN	W. – Nr.
400	N0440 0	NiCu 30 Fe	2.4360
-	-	LC – NiCu 30 Fe	2.4361
-	-	G – NiCu 30 Nb	2.4365
K500	N0550 0	NiCu 30 Al	2.4375
-	-	NiCu 14 FeMo	2.4400

PACKING

25 kg (pail) : SAP stock number : 42016