Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK Autrod NiCu-7

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
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REASON FOR ISSUE

Product name changed from OK Autrod 19.93 to OK Autrod NiCu-7. TÜV added on the label.

GENERAL

A continuous solid nickel based electrode alloyed with 30 % Cu for welding of base materials of the same type. Can also be used to join these alloys to steel. The weld metal has good resistance to flowing seawater and has high strength and toughness over a rather wide temperature range. This alloy also has good resistance to hydrofluoric acid, sulfuric acid, alkalis etc. Can be used for welding of similar types of base materials which are age-hardenable with small additions of Ti and Al. Usable for cladding on carbon steel with an intermediate layer of OK Autrod Ni-1.

Alloy Type: Alloyed nickel (Ni + 30 % Cu + 2 % Ti + 2 % Fe)

CLASSIFICATIONS Wire Electrode		APPROVALS	
SFA/AWS A5.14	ERNiCu-7	VdTÜV	12660 (MV)
EN ISO 18274	S Ni 4060 (NiCu30Mn3Ti)	VdTÜV	12668 (FP)

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.03		0.15
Si	0.3		1.0
Mn	3	2.0	4.0
P	0.01		0.02
S	0.01		0.015
Ni	64	62.0	69.0
Nb	0.1		0.5
Cu	28	28.0	32.0
Al	0.03		1.0
Ti	2	1.5	3.0
Ta	0.01		
Fe	2	0.5	2.5
Others tot			0.50

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
Ø	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max
1.2	160	280	18		3,6	6	6	10	24	30

W = Gas consumption (l / min)
η = Recovery, g weld metal / 100g wire (%)
H = Deposit rate (kg weld metal / hour arc time)
Feed = Feeding rate (m/min)
U = Arc voltage (V)