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| Prepared by Benjamin Mousa | Qualified by Tero Tolonen | Approved by Mikael Mimer | Reg no EN006304 | Cancelling None | Reg date 2013-11-26 | Page 1 (1) |
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REASON FOR ISSUE

New product name.

GENERAL

Bare nickel based welding rods 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. Has also 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.

Shielding Gas: I1, I2, I3 (EN 439)

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

CLASSIFICATIONS Wire Electrode

| | |
|---------------|-------------------------|
| SFA/AWS A5.14 | ERNiCu-7 |
| EN ISO 18274 | S Ni 4060 (NiCu30Mn3Ti) |

APPROVALS

| | |
|-------|------------|
| VdTÜV | 12661 (MV) |
| VdTÜV | 12669 (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 | |