



# Selectarc CuNi10

Copper Nickel  
basic coated Electrode

## Classification

DIN 1733: EL-CuNi10Mn

Corresponds to EN14640 : Cu 7061 - CuNi10

## Characteristics

Basic coated copper nickel electrode for joining CuNi-alloys with up to 10%Ni and for surfacing the final layer on CuNi70/10 clad steel. The weld metal is resistant against seawater. The electrode can be welded in all positions except vertical down, the slag is easy to remove and the weld beads are regular.

## Applications

Ship building, Oil refineries, Desalination plants

### Base Materials

UNS	Alloy	DIN	Material N°
C70600	CuNi90/10	CuNi10Fe1Mn	2.0872

## Typical Weld Metal Composition ( % )

C	Si	Mn	Ni	Fe	Ti	Pb	Cu
0.02	0.30	1.20	10.00	1.20	0.20	0.01	base

## All Weld Metal Mechanical Properties( As Weld)

Conditions	YS Rp0.2(MPa)	UTS Rm (MPa)	% Elg A <sub>5</sub>
AW	245	330	30

## Welding Current & Instructions

Electrode	Ø x L (mm)	2.5 x 300	3.2 x 350	4.0 x 350
Current	(A)	55 - 75	80 - 100	110 - 130

Rebaking for 2h at 200-250°C. Joints to weld must be clean, exempt from grease, cracks.

Guide electrodes with a slight declination, weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2 times core wire diameter). Interpass temperature <150°C. When applied on steel, use Selectarc Ni190 as intermediate layer.



1G/PA



2F/PB



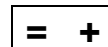
2G/PC



3G/PF



4G/PE



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