



UP Ni60

Monel Submerged Arc Wire

Classification

AWS A 5.14: ER NiCu7 EN ISO 18274: SNi4060 (NiCu30Mn3Ti)
 UNS: N04060

Characteristics

Nickel-Copper alloy (Monel NiCu7) is Submerged arc welding wire used for welding of MONEL Alloys 400, R404, and K 500. It is also used for overlay of Steel by this process. This wire to be used in combination of UP NiO₂ flux for consistent quality and Corrosion resistance. It has good strength and resists corrosion in many media, including Sea Water salt and reducing acids. The weld metal is not age hardening. Recommended for steels/ Copper-Nickel or steels/Copper/Copper Nickel alloys assemblies.

Applications

For components for Chemical and Petrochemical installations, for Sea water and off shore applications. Chemical industries, Ship building, De-salination equipments...

Base Material:

UNS	ALLOY	DIN	Material No.
C70600	CuNi90/10	CuNi10Fe1Mn	2.0872
C71500	CuNi70/30	CuNi30Mn1Fe	2.0882
N04400	400	NiCu30Fe	2.4360
N05500	K-500	NiCu30A	2.4375

Typical Wire Composition (%)

C	Si	Mn	Fe	Cu	Ti	P	S	Ni
0.03	0.40	3.50	0.60	29.00	2.20	0.010	0.008	Base

All Weld Metal Mechanical Properties

Conditions	UTS Rm (MPa)	YS R _{p0.2} (MPa)	% Elg A=5d	Impact (kv) Temp. °C J
AW UP NiO ₂	500	320	35	+20 120

Parameters

Process	Wire Ø (mm)	Current (A)	Voltage (V)	Travel Speed (cm/min)	Stick Out (mm)	Flux
UP/SAW DC +ve	1.60	200 - 250	27 - 30	45 - 60	~13	UP NiO ₂
	2.00	220 - 330	27 - 30	45 - 60	~16	
	2.40	300 - 360	27 - 30	50 - 70	~19	

Packing & Storage

25 kg Spool for packed in Corrugated Cardboard Boxes. Wire to be Stored in dry conditions.

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