



AWS A5.14 ER NiCu-7  
BS 2901 Pt5: NA 33

## Nickel/Copper Alloy Filler Wire

**NW-1710**

### DESCRIPTION & APPLICATION

Nickel/Copper Alloy Filler Wire for the joining and surfacing of Alloys of a similar composition, (Monel 400) Also suitable for the joining of these Alloys to steel, copper and other copper alloys. Used in high-grade plant/engineering primarily for the petro-chemical industry. A special application is the fabrication of seawater evaporation plant and marine equipment.

### BASE MATERIALS

Monel 400, K-500. Nicorros, LC  
Werkstoffe No. 2.4377  
Nicorros, Nicorros Al  
Steel, Cast Iron,

### MECHANICAL PROPERTIES

>480 UTS n/mm	>280 YIELD 0.2%	>35 ELONG A5%	+20°C. >120 -196°C. >110 CHARPY (J)
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### METAL WELD COMPOSITION %

C	Si	Mn	Cu	Ni	Fe	Ti
0.025	0.59	2.95	295	BAL	1.05	2.2

### PACKAGING

15kg Spools (MIG)  
5kg Tubes (TIG)

### DIAMETERS

0.8, 1.0, 1.2mm (MIG)  
1.6, 2.4, 3.2mm (TIG)

### WELDING INSTRUCTIONS

Thorough cleaning of the weld zone is paramount. 100% Argon gas for TIG applications, Argon/Helium or Argon for MIG or proprietary special gases. Prior to welding, all traces of paint, oil, grease or other sources of hydrocarbons to be removed.