

## IABCO ERNiCu-7

### MIG/GMAW and TIG/GTAW nickel base wire

Product name	IABCO ERNiCu-7		
Classification EN ISO	18274:	S Ni4060 (NiCu30Mn3Ti)	
Material No.	2.4377		
Classification AWS	A5.14:	ERNiCu-7	
Approvals	CE.		
Applications	<p>Nickel-copper base wire, commonly referred to as filler metal 60, used for welding matching alloy 400 (Monel) alloys.</p> <p>The IABCO ERNiCu-7 wire can be used to weld the precipitation hardened N05500 alloy but the weld metal will undermatch the strength of the base material.</p> <p>Alloy 400 has good corrosion resistance to seawater, salts and reducing acids. Typical applications include heat exchangers, piping, pumps, valves and process vessels in the chemical, offshore and marine industries.</p>		
Base materials	<p>Used for welding matching alloys:</p> <p>UNS: N04400, N04405, N05500. EN: 2.4360, 2.4361, 2.4375. Proprietary: Nicorros 400 (Outokumpu VDM), Monel 400/R405/K500 (Special Metals).</p>		
Typical analysis of wire, weight %	C:	0.01	Si: 0.10
	Mn:	3.4	Ni: Balance
	Cu:	30.0	Ti: 1.8
	Fe:	0.7	Al: 0.10
Typical heat treatment <sup>(1)</sup>	<p>Preheat: Not required. Interpass temperature: 150°C. PWHT: Not normally required.</p>		
Typical mechanical properties of weld <sup>(2)</sup>	0.2% proof stress Rp0.2%:	300MPa	
	Tensile strength Rm:	500MPa	
	Elongation 4d/5d:	35%	
	Impact ISO-V, +20°C:	100J	
Other products	-		

**Notes** (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.