



# CEWELD CuNi10Fe Tig

<b>TYPE</b>	Copper-Nickel alloyed TIG welding wire																				
<b>ANWENDUNGEN</b>	The CEWELD® CuNi10Fe Tig is suitable for welding and cladding CuNi-Materials of ISO 17664 and seawater resistant CuZn alloys of ISO 17660 table 3. And also suitable for surfacing on low alloyed and unalloyed steels and grey cast iron.																				
<b>EIGENSCHAFTEN</b>	Sound, pore free deposits on ferrous and non-ferrous base materials.																				
<b>KLASSIFIKATION</b>	EN ISO                    24373: Cu 7061 / CuNi10 W.Nr.                    2.0873 F-nr                      37																				
<b>GEEIGNET FÜR</b>	Cunifer 10, cuni10fe, seawater resistant, marine applications, tubes, pump building, offshore etc.																				
<b>ZULASSUNGEN</b>																					
<b>SCHWEISSPOSITIONEN</b>																					
<b>TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)</b>	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Ti</th> <th>Fe</th> <th>Cu</th> <th>Pb</th> <th>Ni+Co</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.1</td> <td>1.1</td> <td>0.01</td> <td>0.01</td> <td>0.4</td> <td>1.5</td> <td>Rem.</td> <td>0.01</td> <td>10</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Ti	Fe	Cu	Pb	Ni+Co	0.02	0.1	1.1	0.01	0.01	0.4	1.5	Rem.	0.01	10
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<b>MECHANISCHE GÜTEWERTE</b>	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>p0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td></td> <td>300</td> <td>34</td> <td colspan="2">190</td> <td>80 HB</td> </tr> </tbody> </table>	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	RT		As Welded		300	34	190		80 HB				
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<b>RÜCKTROCKNUNG</b>	Not required																				
<b>GAS ACC. EN ISO 14175</b>	I1, I3																				



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CUNI10FE TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663409485
CUNI10FE TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663409492
CUNI10FE TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663409508
CUNI10FE TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663409515