

# CEWELD CuNi10Fe Tig

**TYPE** Copper-Nickel alloyed TIG welding wire

**APPLICATIONS** 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.

**PROPERTIES** Sound, pore free deposits on ferrous and non-ferrous base materials.

**CLASSIFICATION** EN ISO 24373: Cu 7061 / CuNi10  
 W.Nr. 2.0873  
 F-nr 37

**SUITABLE FOR** Cunifer 10, cuni10fe, seawater resistant, marine applications, tubes, pump building, offshore etc.

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

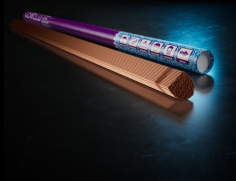
| C    | Si  | Mn  | P    | S    | Ti  | Fe  | Cu   | Pb   | Ni+Co |
|------|-----|-----|------|------|-----|-----|------|------|-------|
| 0.02 | 0.1 | 1.1 | 0.01 | 0.01 | 0.4 | 1.5 | Rem. | 0.01 | 10    |

**MECHANICAL PROPERTIES**

| 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    |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1, I3



# CEWELD CuNi10Fe Tig

|                           |           |         |               |
|---------------------------|-----------|---------|---------------|
| 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 |