

Description & Applications

ZULFI SR ERNiCu has a nominal composition (wt.-%) of 30 Ni, 68 Cu weld metal. This filler metal can be used for TIG overlay on steel after a first layer with ZULFI SR ERNi-1.

ZULFI SR ERCuNi is used for joining base materials such as UNS number C71500. This includes ASTM grades such as B111, B122, B151, B171, B359, B395, B432, B466, B467, B543, and B552. This alloy can be used for dissimilar welding applications welding various copper-nickel alloys to nickel alloys and various other copper-nickel alloys.

Shielding Gas

Ar

Welding current

DC-

Classifications

SFA/AWS A5.7 ERCuNi

All weld metal typical composition, %

C	Si	Mn	Ni	Ti	Cu
0.020	0.20	0.50	30.00	0.30	68.00

All weld metal typical mechanical properties,

Yield strength, MPa	≥200
Tensile strength, MPa	≥350
Elongation, %	≥20

Approvals

Welding parameters

Diameter, mm	Voltage, V	Current, A	Gas flow rate, LPM	Package Weight, kg
1.6	6-12	35-80	10-15	5
2.0	6-13	45-100	10-15	5
2.4	7-14	55-120	10-15	5
3.2	8-15	65-150	10-15	5

- Available in plastic tube.