

DESCRIPTION

- Basic agglomerated flux designed for joining and cladding with a cupronickel alloy.
- In case of cladding on mild steel, it is advised to deposit first a NiCu buffer layer (Soudor NiCu 7 + Record NiCuW).

GENERAL CHARACTERISTICS

- Current DC (+ and -) and AC – 800 A max.
- Basicity index 1 (according to Bonizewski; calculated in mole %)
- Grain size 0.4 - 1.4 mm (14 x 40 N° ASTM)
- Apparent density 0.75
- Consumption 0.35 (kg fused flux / kg wire)
- Redrying 1 to 2 hours at 350 +/- 50°C

TYPICAL ALL WELD METAL ANALYSIS AND WIRE ANALYSIS (WEIGHT%)

Wire	ASME IIC SFA 5.7	DIN 1733	C	Mn	Si	Ni	Cu
Soudor CuNi 30	ERCuNi 30	UP-CuNi30Fe	0.02	1.0	0.10	31.0	balance
Pure weld metal			0.02	1.0	0.30	30.0	balance

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Wire	Rm [MPa]	Rp0.2 [MPa]	A5 [%]	Av [ISO – V]
Soudor CuNi 30	350	180	40	100 J: + 20°C

SUITABLE FOR

UNS	DIN	W. – Nr.
-	CuNi30 Mn	2.0890
C71500	CuNi30 Mn1 Fe	2.0882
C70600	CuNi10 Fe1 Mn	2.0872
C71000	CuNi20 Fe	2.0878
C71300	CuNi25	2.0830
-	CuNi44 Mn	2.0842

PACKING

25 kg (pail) : SAP stock number : 29097