

ASME II C SFA 5.7 : ER CuNi  
W-Nr. : 2.0837

## DESCRIPTION

- SOUDOTAPE CuNi30 is a strip designed for submerged-arc strip cladding of 70Cu 30Ni Alloy.
- This strip is used for multilayer cladding in combination with flux RECORD CuNi30T.
- In case of cladding on C-steel, a buffer layer with Soudotape NiCu7 and Record NiCuT is necessary.

## TYPICAL STRIP ANALYSIS

C	Mn	Si	Ti	Ni	Cu	Fe
0.025	0.8	0.10	0.3	30.7	Bal.	0.7

## TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Base metal 0.18 % C - steel.
- Strip dimensions 60 x 0.5 mm
- Cladding parameters (1) : 900 A - 26 V - 14 cm/min.  
(2) : 750 A - 28 V - 14 cm/min.

Alloy	Layer	Strip Soudotape	C	Mn	Si	Cu	Ni	Fe	Ti	Thickn. (mm)
70Cu	-	NiCu7+	0.020	3.5	0.2	29.4	bal.	0.3	2.3	-
	1	Record Ni CuT (1)	0.04	2.7	1.0	24	bal.	16.0	0.4	5
30Ni	-	CuNi30+	0.025	0.8	0.10	Bal.	30.7	0.7	0.3	-
	2	Record CuNi30T (2)	0.03	1.0	0.40	bal.	38	5.0	0.25	4.7
	3		0.02	0.9	0.30	bal.	32	2.0	0.2	4.7

## AVAILABLE STRIP SIZES

- Standard : 30 x 0.5 mm or 60 x 0.5 mm.
- Other sizes on request.

## PACKING

- 30 x 0.5 mm : 25 kg to 30 kg.
- 60 x 0.5 mm : 50 kg to 60 kg.
- Other sizes on request.

**Note** : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.