

GETIG 811

IDENTIFICATION

Getig 811, ERNiCu7

CLASSIFICATION

AWS/SFA 5.14 ERNiCu7, 1736 SG - NiCu30MnTi (2.4377)

DESCRIPTION

Nickel base filler wire suitable for joining and surfacing of Nickel Copper - clad steels. The welds are of X-ray / radiographic quality. Mn & Ti are added for refinement and for suppressing porosity.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Al	Fe	Ni	Cu	Ti
0.15 Max	4.0 max	1.25 max	0.015 max	0.02 max	1 max	2.5 max	62.0 - 69.0	Balance	1.5 max

TYPICAL APPLICATIONS

- For surfacing nickel copper alloys, nickel copper clad steel.
- Chemical and petrochemical industries fabrication of sea water evaporation plants and marine equipments.
- ASTM UN NO 4400, UNS NO 440S, NO 5500.
- Inco Monel 400, R405, K500.
- Heat exchangers, piping, vessels.

WELDING INSTRUCTIONS

Clean thoroughly the welding area / zone. Vee angle of the butt joint should be 70°C.

SHIELDING GAS : Pure Argon 99.99% plus back purging

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20