

# GETIG 812

## IDENTIFICATION

Getig 812, ERCuNi

## CLASSIFICATION

AWS/SFA 5.7: ERCuNi, BS 2901:Pt 3, Grade C 18

DIN 1733:SG-CuNi30Fe

## DESCRIPTION

Copper - nickel solid wire depositing 70Cu-30Ni weld metal. This wire is used for welding similar cupronickel alloys and Cupro-Nickel type 90% Copper 10% Nickel. The weld metal is resistant to sea-water.

## CHEMICAL ANALYSIS (RANGE) %

Ni	Si	Mn	Pb	Ti	P	S	Fe	Cu
30.0 - 32.0	0.20 max	0.5 - 1.0	0.007 max	0.20 - 0.50	0.01 max	0.01 max	0.40 - 0.75	Remainder

## TYPICAL APPLICATIONS

- For-off-shore pipe and cladding systems, desalination plants, evaporators, heat exchangers, etc. condensers and
- Materials to be welded:
- BS: 70CuNi CN103-CN107, ASTM/ASME: CA715/UNS C71500, CA964/UNS C96400
- OTHERS: Kunifer 30 (IMI), Cunifer 30 & 302 (VDM).
- Also suitable for welding 90/10 cupronickels below:
- 90CuNi CN101 CA 706/UNS C70600 Kunifer 0 (IMI)
- CN102 CA 962/UNS C96200 Cunifer 10 (VDM)

**SHIELDING GAS** : Pure Argon (99.99%)

## 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