

GM 811

SOLID WIRE FOR MIG WELDING

IDENTIFICATION

GM 811, ERNiCu7

CLASSIFICATION

AWS/SFA 5.14 ERNiCu7, DIN 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	1.25 max	2.50 max	62.0 - 69.0	Balance	1.5 - 3.0

MECHANICAL PROPERTIES (RANGE)

TS (N/mm ²)	EL (%) (L=4D)
480 - 580	30 - 40

TYPICAL APPLICATIONS

- For surfacing nickel copper alloys, nickel copper clad steel.
- Chemical and petrochemical industries fabrication of sea water evaporations 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)	Weight / Spool (kg)
0.8	12.5
1	12.5
1.2	12.5