

GM 812

SOLID WIRE FOR MIG WELDING

IDENTIFICATION

GM 812, ER CuNi

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, corrosion.

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	balance

MECHANICAL PROPERTIES (RANGE)

UTS (N/mm ²)	PS (N/mm ²)	EL (%) (L=4D)	Hardness (SHV)
345 - 430	180 - 250	40	105

TYPICAL APPLICATIONS

- For-off-shore pipe and cladding systems, desalination plants, condensers and evaporators, heat exchangers, etc.
- 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)	Weight / Spool (kg)
0.8	12.5
1	12.5
1.2	12.5