

## ERCuNi

AWS A5.7 ERCuNi

### Description:

ERCuNi is used for joining base materials such as UNS number C71500, including ASTM grades such as B111, B122, B151, B171, B359, B395, B432, B466, B467, B543, and B552.

It is also used for welding various copper-nickel alloys to nickel alloys and various other copper-nickel alloys.

### Diameters:

1.2/1.6mm

### Typical Mechanical Properties:

Tensile strength(MPa):	366
Yield strength(MPa):	155
Elongation(%):	32
Impact values( $\geq 47$ )/(-20 °C):	—

### Typical Chemical Composition:

C	Mn	P	S	Si	Ni+Co	Cu+Ag	Al	Ti
0.03	0.75	0.006	0.003	0.02	30.5	69.00	0.03	0.39

### Welding Current:(DC+)

Diameter(mm)	1.2	1.6
Current/A	75-160	120-300
Voltage/V	19-22	20-32
Gas speed/(L/Min)	20-25	20-25

Note:

- 1, Rusty, water, oil and other impurity should be cleaned before welding.
- 2, Use 75% Ar+25% He as shielding gas