

# WISDOM Welding Consumables

## Nickel based alloy



**AWS ERNiCu-7**

**DATA SHEET**

November 2015

### Key features:

- ① used for GTAW, GMAW, and submerged-arc welding of monel alloy 400, 404 and k-500.
- ② also used for overlaying steel after first applying Layer of 610 nickel.
- ③ used for dissimilar welding applications using various nickel-copper alloys to nickel200 and to copper-nickel alloys.

### Conformances

ASME SFA 5.14

UNS N04060

AWS 5.14

CHEMICAL COMPOSITION(%)					
C	Si	Mn	S	P	Ni
≤0.15	≤1.25	≤4.0	≤0.015	≤0.02	62-69
Al	Ti	Fe	Cu	others	
≤1.25	1.5-3.0	≤2.5	Rest	<0.5	

MECHANICAL PROPERTIES		
<b>Tensile Strength</b>	76,500 PSI	530 MPA
<b>Yield Strength</b>	52,500 PSI	360 MPA
<b>Elongation</b>	34%	

Diameter & Packaging			
Form	Diameter	Standard Packaging	
		spool	tube
TIG	1/16" (1.6mm)	15kg/spool	5kg/tube
	3/32" (2.4mm)	15kg/spool	5kg/tube
	1/8" (3.2mm)	15kg/spool	5kg/tube
MIG	.035" (0.9mm)	15kg/spool	5kg/tube
	.045" (1.2mm)	15kg/spool	5kg/tube
	1/16" (1.6mm)	15kg/spool	5kg/tube