



Characteristics and scope of application

- Filler metal for CuNi alloys used in maritime applications and seawater environments
- Typically used in heat exchangers in contact with seawater, desalination plants and chemical process industry
- Recommended for dissimilar welds of CuNi alloys and other Cu alloys

Standard designations

DIN EN ISO 24373	AWS A5.7	DIN Mat.-No.
S Cu 7061 (CuNi10)	-	2.0873

Typical chemical composition of filler metal

	C	Ni	Cu	Mn	Fe	Ti
Mass %	0.03	10	Bal.	0.9	1.2	0.4

All weld metal properties (min. values at rt)

Heat treatment	Yield strength	Tensile strength	Elongation	Impact toughness	
	R _{p0.2}	R _m	A ₅	ISO-V	
as welded	160 MPa	320 MPa	30%		

Welding instructions

Polarity	Shielding gas acc. to DIN EN ISO 14175
DC / +	I1, I3
DC / -	I1, I3

Low heat input and interpass temperature < 120°C. Stringer bead technique recommended.

Base materials
2.0872 – CuNi10Fe1Mn
2.0882 – CuNi30Mn1Fe

Packaging (tolerances acc. to DIN EN ISO 544)

Approvals on request

Diameter (mm)		Kg
1.6 / 2.0 / 2.4 / 3.2	X 1000 mm	5 / 10
0.8 / 1.0 / 1.2	BS 300 spool	15
1.6 / 2.4 / 3.2	K 415 / K 435 spool	25