



### Characteristics and scope of application

- Filler metal for CuNi-Legierungen 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 <sub>p0.2</sub>	R <sub>m</sub>	A <sub>5</sub>	ISO-V	
as welded	160 MPa	320 MPa	30%		

### Welding instructions

Polarity	Shielding gas acc. to AWS A5.32
DC / +	SG-A, SG-AHe
DC / -	SG-A, SG-AHe

Low heat input and interpass temperature < 248°F. Stringer bead technique recommended.

Base materials
2.0872 – Cu Ni10Fe1Mn
2.0882 – CuNi30Fe1Mn

### Packaging (tolerances acc. to AWS A5.02)

Approvals on request

Diameter (in)		lbs/PU
1/16 - 1/8	x 36 in	11 / 22
0.8 / 1.0 / 1.2	BS 300 spool	33
1.6 / 2.4 / 3.2	K 415 / K 435 spool	55