

CARBO S-2.4377

CARBO T-2.4377

International standards

	S = solid wire	T = bare rod
Mat. No.	2.4377	
DIN 1736	SG-NiCu 30 Mn Ti	SG-NiCu 30 Mn Ti
AWS A 5.14	ERNiCu-7	ERNiCu-7

Approvals

Application notes

Solid Nickel copper welding wire electrode suitable for joining nickel copper alloys and copper to steels (black to red metals) , claddings and buffer layers

Operating temperature

-196° C up to + 425° C

Base materials

2.4360 NiCu 30 Fe
2.4361 LC-NiCu 30 Fe
2.4365 G-NiCu Nb
2.4375 NiCu 30 Al

Mechanical properties of all-weld-metal

(typical values)

Tensile strength R _m N/mm ²	Yielding strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact strength ISO – V J at -40° C
500	300	35	120

Weld metal analysis

(typical, wt %)

C	Mn	Cu	Ni	Fe
0,02	3,30	30,0	Basis	1,0

Gas types EN 439

S = solid wire

I1

T = bare rod

I1

Current

Diameter mm
Welding amps (A) min.
(A) max.

= +					= -				
0,8	1,0	1,2	1,6		1,6	2,0	2,4	3,2	4,0
80	120	180	200						
140	160	220	260						

coils, weight

Rev. 002/13

B300 15 kg.

10 kg.