

Cu-Ni Filler Metal

MONEL® Filler Metal 67

MONEL Filler Metal 67 is used for oxyacetylene, gas-tungsten-arc, gas-metal-arc, and submerged-arc welding of MONEL alloy 450 (70/30 Copper-Nickel) and other copper-nickel alloys. It is used for surfacing of steel if a barrier layer of Nickel Filler Metal 61 is first applied. If applied by the submerged-arc process, MONEL Filler Metal 60 can be used for the barrier layer.

The copper-nickel weld metal has excellent resistance to corrosion in sea water, and is widely used for marine and desalination applications.

Dissimilar-welding applications for MONEL Filler Metal 67 are joints between MONEL alloys or Nickel 200 and copper-nickel alloys.

Specifications

- AWS A.5.7 ERCuNi (UNS C71581)
- ASME II, Part C, SFA-5.7, ERCuNi (UNS C71581)
- ASME IX, F-No.34
- *BS 2901 (C18)
- *DIN 1733 SG-CuNi30Fe (2.0837)
- *(EN) ISO SCu 7158 (CuNi30)
- *Supply to these specifications available upon request
- For manufacture to ASME III (NCA3800, NB2400), MIL, and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

- VdTUV 4528.00; 4529.00
- Other approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition	Ni+Co..... 29.0-32.0		Si 0.25 max.	
	C..... 0.04 max.		Ti 0.20-0.50	
Mn 1.0 max.		P 0.02 max.		
Fe..... 0.40-0.75		Pb..... 0.02 max.		
S..... 0.01 max.		Others 0.50 max.		
Cu Remainder				

Minimum Mechanical Properties	Tensile Strength, psi		50,000	
		MPa		345
	Elongation, (4d) %		30	

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

Available Product Forms

mm in	0.8	0.9	1.0	1.14	1.2	1.6	2.4	3.2
	0.030	0.035	0.040	0.045	0.047	0.062	0.093	0.125

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)

Wire Diam.	13.62 kg Spool
0.9mm	SMMMMONEL6709
1.2mm	SMMMMONEL6712

Rod Diam.	4.54 kg Tube
1.6mm	SMTMONEL6716
2.4mm	SMTMONEL6724

TALARC Pty Ltd
10-16 Syme St
Brunswick, Vic 3056
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710
W: www.talarc.com E: sales@talarc.com