TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP CuNi10

COPPER ALLOYS

CLASSIFICATIONS

EN ISO 24373
S Cu 7061 (CuNi10)

KEY FEATURES AND APPLICATIONS

- Solid copper-nickel wire used for welding and cladding on CuNi materials.
- Ideal for seawater corrosion-resistant CuZn alloys, it is also suitable for surfacing on highly stressed cast iron and unalloyed and low-alloy steels.
- Preheating is generally not necessary.
- Typically used for marine applications, tubes, pump building, offshore etc.

BASE MATERIALS

CuNi5Fe (2.0862), CuNi10Fe1Mn (2.0872), Cunifer 10, Cuni10fe

CHEMICAL COMPOSITION OF WIRE %

	Cu	Fe	Mn	Ni incl. Co	P	Pb	Si	C	Ti	S	Others
MIN	Bal.	0.5	0.5	9.0	-	-	-	-	0.1	-	0.4
MAX		2.0	1.5	11.0	0.02	0.02	0.2	0.05	0.5	0.02	

Single values are maximum values according to EN ISO 24373 unless otherwise stated

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Tensile Strength (MPa)	Hardness (HB)	Melting Temperature
~300	~80	1100 - 1145°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - I1, I3	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP40377	1.6	1000	5	PAP 20 Tube
XP40378	2.4	1000	5	PAP 20 Tube
XP40379	3.2	1000	5	PAP 20 Tube