

90CuNi

TIG (GTAW)

SOLID 90/10 CUPRONICKEL WIRE FOR TIG

PRODUCT DESCRIPTION

Solid wire for TIG welding

CLASSIFICATIONS

ISO 24373 S Cu 7061 / CuNi10

ASME IX QUALIFICATION

QW432 F-No 34

CHEMICAL COMPOSITION (WIRE WT %)

	Mn	Si	S	P	Cu	Ni	Fe	Ti	Pb	C
min.	0.5	--	--	--	bal	9.0	0.5	0.1	--	--
max.	1.5	0.2	0.02	0.02	--	11.0	2.0	0.5	0.02	0.05
Typical	0.8	0.02	0.001	0.002	86	10.5	1.2	0.3	0.001	0.01

ALL-WELD MECHANICAL PROPERTIES

As welded	Typical
Tensile strength (MPa)	365
0.2% proof strength (MPa)	200
Elongation [%] 5d	40
Hardness cap/mid (HV)	105

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon or Ar + 1-5% H ₂	DC-	2.4	100A, 12V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	2.5	PE TUBE	T90CUNI-16
2.0	2.5	PE TUBE	T90CUNI-20
2.4	2.5	PE TUBE	T90CUNI-24
3.2	2.5	PE TUBE	T90CUNI-32

NICKEL BASE ALLOYS