

ASME II C SFA 5.14 : EQ NiCu-7
 EN ISO 18274 : ca B Ni 4060
 DIN 1736 : UP-NiCu30MnTi
 W-Nr. 2.4377

DESCRIPTION

- SOUDOTAPE NiCu 7 is a strip designed for submerged-arc and electroslag strip cladding of alloy 400.
- This strip is used for multilayer cladding in combination with fluxes RECORD NiCuT or RECORD EST 400.

SUITABLE FOR

- Chemical & marine engineering, desalinisation processing, heat exchangers, applications requiring an excellent corrosion resistance against aggressive media including sea water, alkalies, hydrofluoric & sulphuric acids.

TYPICAL STRIP ANALYSIS

C	Mn	Si	Ti	Ni	Cu	Fe
0.02	3.4	0.2	2.3	Bal.	29.4	0.3

TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Submerged arc strip cladding with RECORD NiCuT on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Ti	Ni	Cu	Fe	Thickn. (mm)
2 nd Layer (alloy 400)	NiCuT	0.018	3.2	1.0	0.33	Bal.	28.1	7.1	4.7

- Electroslag strip cladding with RECORD EST 400 on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Ti	Ni	Cu	Fe	Thickn. (mm)
2 nd Layer (alloy 400)	EST 400	0.016	3.3	0.5	0.69	Bal.	28.2	2.0	5

AVAILABLE STRIP SIZES

- Standard : 30 x 0.5 mm or 60 x 0.5 mm.
- Other sizes on request.

PACKING

- 30 x 0.5 mm : 25 kg to 30 kg
- 60 x 0.5 mm : 50 kg to 60 kg
- Other sizes on request.

Note : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.