

# Product Data Sheet



**BRAND NAME** VJ ERNiCu-7

**AWS/ASME Class** ERNiCu-7

**SPECIFICATION** SFA A5.14

## Features and Applications :

VJ ERNiCu-7 is a nickel-copper alloy solid wire for TIG welding.its suitable for dissimilar welding between nickel-copper alloys, Nickel 200, and copper-nickel alloys. For carbon steel overlays.It gives radiographic quality welds.

## CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.03	Ni	63.50
Mn	0.85	Ti	2.50
Si	0.20	S	0.01
P	0.01	Cu	30.00

## MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As weld	
Properties	Typical
UTS (MPa)	530
El (%)	30

## DIMENSIONS:

GTAW	
Dia (mm)	Lengh (mm)
1.6	1000
2.0	1000
2.4	1000
3.2	1000

**GTAW CURRENT** : DCEN

**SHIELDING GAS:** ARGON

## PACKING :

**GTAW** : 5 kg wire put in an air-tight polythene bag and finally packed in a plastic container. Identification AWS code is punched on side of wire.

## WELDING POSITION:

