

Cupronic 70 is suitable for the welding or facing of alloys having the same chemical composition. The weld metal has excellent mechanical properties and a high resistance to chemical corrosion in saline environments. Typical applications include desalination plants.  
Efficiency 100%.

### Classification

AWS A5.6: E CuNi

### Approvals

MMI

### Grades

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	Cu	Sn
0.008	1.40	0.02	≤ 0.010	≤ 0.010	-	29.40	-	-	0.50	Rem	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	-	≥ 350	≥ 20	-	-

### Materials

2.0872 (CuNi10Fe1Mn9); 2.0882 (CuNi30Mn1Fe)  
UNS C70600; UNS C71500

### Storage and redrying

Keep dry and avoid condensation.  
Re-dry at 280-300 °C for 1 hour, 5 times max.

### Current condition and welding position

DC+; AC



### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	50-70	17,8	10,7
3,2	350	75-100	35,4	21,2
4,0	350	90-130	53,5	32,1