

MONEL[®] Filler Metal 67

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MONEL Filler Metal 67 is used for oxyacetylene, gas-tungsten-arc, gas-metal-arc, and submerged-arc welding of MONEL alloy 450 (70/30 Copper-Nickel) and other copper-nickel alloys. It is used for surfacing of steel if a barrier layer of Nickel Filler Metal 61 is first applied. If applied by the submerged-arc process, MONEL Filler Metal 60 can be used for the barrier layer. Submerged-arc welding with MONEL Filler Metal 67 is done with INCOFLUX 8 Submerged Arc Flux.

The copper-nickel weld metal has excellent resistance to corrosion in sea water, and is widely used for marine and desalination applications.

Dissimilar-welding applications for MONEL Filler Metal 67 are joints between MONEL alloys or Nickel 200 and copper-nickel alloys.

Specifications

AWS A5.7 ERCuNi (UNS C71581)

ASME II, Part C, SFA-5.7, ERCuNi (UNS C71581)

ASME IX, F-No.34

*BS 2901 (C18)

*DIN 1733 SG-CuNi30Fe (2.0837)

*(EN) ISO SCu 7158 (CuNi30)

*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), MIL, and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

VdTUV 4528.00; 4529.00

Other approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition	Ni+Co.....	29.0-32.0	Si	0.25 max.
	C.....	0.04 max.	Ti	0.20-0.50
	Mn	1.0 max.	P.....	0.02 max.
	Fe.....	0.40-0.75	Pb.....	0.02 max.
	S.....	0.01 max.	Others	0.50 max.
	Cu	Remainder		

Minimum Mechanical Properties	Tensile Strength, psi	50,000
	MPa	345
	Elongation, (4d) %	30

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

Available Product Forms

mm in	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125
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Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)