

SMT-7030

Conformances

AWS A5.7/ ASME SFA5.7 ERCuNi
 JIS Z3341 YCuNi-3
 ABS AWS A5.7 ERCuNi

Applications

- Desalination plant
- Evaporators and etc in salt and sea water processing system

Features

- No preheat & PWHT required, maximum interpass temperature 150°C
- Contamination of the weld zone with foreign material, particularly any source of lead, tin or zinc must be scrupulously avoided to prevent weld metal cracking

Welding Position

Current

GMAW: DC+(Pulse)
 GTAW: DC-

Shielding Gas

Ar, Ar + He

Diameter / Packaging

Diameter	MIG	TIG
mm (in)	12.5kg (27.6lbs)	5kg (11lbs)
1.0 (0.040)	✓	
1.2 (0.045)	✓	
1.4 (0.052)	✓	
1.6 (1/16)	✓	
2.0 (5/64)		✓
2.4 (3/32)		✓
3.2 (1/8)		✓

Typical Chemical Composition of the Wire (%)

C	Si	Mn	P	S	Ni	Ti	Cu	Fe
0.02	0.10	0.8	0.001	0.001	31.0	0.4	67.0	0.6

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
-	500 (73,000)	30.0		

Typical Welding Parameters

Diameter, Polarity Shielding Gas	Amp. (A)	Volt. (V)
	1.2mm (0.045 in) DC+	
Ar, Ar + He	160	28
	2.4mm (3/32 in) DC-	
Ar	110	12