

EN ISO 18274:2004: S Ni 4060
(NiCu30Mn3Ti)
DIN 1736: SG- NiCu30Mn3Ti
AWS 5.14-97: ER NiCu7
W.Nr.: 2.4377

BÖHLER NIBAS 400-IG

GTAW rod,
nickel copper

Description

GTAW rod for joining and surfacing of nickel-copper alloys and of nickel-copper-clad steels. Particularly suited for the following materials: alloy 400, N04400, 2.4360 NiCu30Fe, 2.4375 NiCu30Al. It is also used for joining different materials, such as steel to copper and copper alloys, steel to nickel-copper alloys. . Excellent corrosion resistance to chloride induced stress corrosion cracking and a wide range of marine and chemical requirements. These materials are employed in high-grade apparatus construction, primarily for the chemical and petrochemical industries. A special application field is the fabrication of seawater evaporation plants and marine equipment.

Typical Composition of All-weld Metal

	C	Si	Mn	Ni	Cu	Ti	Fe	Al
wt-%	<0.02	0.3	3.2	bal.	29	2.4	1	<1.0

Mechanical Properties of All-weld Metal

	u
yield strength R_e N/mm ² :	300
tensile strength R_m N/mm ² :	500
elongation A ($L_0=5d_0$) %:	35
impact work ISO-V KV J	150

u untreated, as-welded

Operating Data



shielding gases:

100% Argon

rod marking:

front: ✦ **2.4377**

back: **ER NiCu7**

ø mm

1.6

2.0

2.4



Base Materials

NiCu30Fe (2.4360), NiCu30Al (2.4375)
UNS N04400, N05500,
nickel copper alloys, Alloy 400, ASTM B 127, B 165

Approvals and Certificates

TÜV-D, (10521.) ABS, GL, CL

Same-alloy Filler Metals

SMAW: FOX NIBAS 400
GMAW solid wire: NIBAS 400-IG