

CARBO CuNi 30 Mn

International standards	Material No.	2.0837
	DIN 1733	EL-CuNi 30 Mn
	AWS A 5.6	E CuNi

Approvals ---

Characteristics and typical applications

CARBO CuNi 30 Mn is a copper-nickel electrode with a basic coating for joining and surfacing alloys of similar composition with up to 30% nickel as well as non-ferrous alloys and dissimilar steel grades. The deposit weld metal is highly resistant to seawater, typical applications include usage in shipbuilding, oil refineries, food processing industry, the engineering of general corrosion proof vessels and equipment.

Base materials

- Cooper-nickel alloys up to 30% Ni content
- CuNi30Mn, CuNi30Mn1Fe, CuNi10Fe1Mn, CuNi20Fe, CuNi25, CuNi44Mn
- Material No. 2.0890, 2.0882, 2.0872, 2.0878, 2.0830, 2.0842
- Dissimilar joining nickel to copper-nickel alloys

Mechanical properties of all-weld metal (typical values)

Tensile strength MPa	0,2% Yield strength MPa	Hardness HB	Elongation A ₅ %
≥ 390	≥ 240	105	≥ 25

Weld metal analysis (typical, wt %)

C	Mn	Si	S	P	Fe	Cu	Ni
0,015	1,80	0,40	0,010	0,15	0,60	Bal.	30,0

Current = +

Welding positions PA, PB, PC

Rebaking 1 h, 90° C + / - 10° C (if necessary)

Rev. 000