

Technical Data Sheet

AMPCO-TRODE® 521

SG- CuNi30Fe

Rod/wire electrode for copper

Classification

ISO 24373 S Cu 7158 (CuNi30Mn1FeTi)

DIN 1733 SG-CuNi30Fe

Material No. 2.0837

AWS A 5.7 ER CuNi

BS 2901 part 3 C 18

Base materials

Particularly suitable for high stressed corrosion resistant weld surfacing on cast iron and on unalloyed and low- alloyed steel as well as seawater resistant CuZn alloys. Suitable for welding on CuNi

Physical properties (Approx. values)Electrical conductivity [$S \cdot m/mm^2$] 2

Therm. conductivity [W/m K] 30

Density [kg/dm^3] 8,9Melting temperature [$^{\circ}C$] 1.210

Tensile strength Rm [MPa] 400

Elongation A5 ($L_0=5d_0$) [%] 35**Typical composition in %**

Ni 29,0 - 32,0

Fe 0,4 - 1,0

C < 0,05

Mn 0,5 - 1,5

Si < 0,2

Ti 0,2 - 0,5

S < 0,015

P < 0,02

Pb < 0,02

Others total < 0,5

Shielding gas

(Argon, Helium or Argon/Helium-mixtures)

