

Technical Data Sheet

AMPCO-TRODE[®] 522

ML CuNi10Fe

Rod/wire electrode for copper

Classification

ISO 24373 S Cu 7061 (CuNi10)

DIN 1733 SG-CuNi10Fe

Material No. 2.0873

BS 2901 part 3 C 16

Base materials

Particularly suitable for highly stressed corrosion resistant weld surfacing on cast iron and on unalloyed and low-alloyed steel, seawater resistant CuZn alloys. Appropriate to joining/surfacing on Cu-Ni material. Especially recommended for plant engineering.

Physical properties (Approx. values)

Electrical conductivity [$S \cdot m/mm^2$] 5

Therm. conductivity [$W/m K$] 45

Density [kg/dm^3] 8,9

Melting temperature [$^{\circ} C$] 1.150

Tensile strength R_m [MPa] 350

Elongation A_5 ($L_0=5d_0$) [%] 40

Modulus of elasticity [MPa] 126.000

Typical composition in %

Ni 9,0 - 11,0

Fe 0,5 - 2,0

C < 0,03

Mn 0,5 - 1,5

Si < 0,2

Ti 0,2 - 0,5

Al < 0,03

S < 0,02

P < 0,007

Pb < 0,02

Others total < 0,4

Shielding gas

(Argon, Helium or Argon/Helium-mixtures)

