

DIF-FILL 402

COPPER-NICKEL FILLER WIRE
 FOR TIG , MIG , MAG WELDING

Known as cupronickel alloy Suitable for TIG, MIG welding. Ideal for Corrosion resistance, Excellent creep resistance, suitable for temperature ranging from -196 °C to 450 °C

Applications:-

Suitable for welding of Monel and claded steel, Ni-Cu alloys, low and high alloyed steels. Surfacing of steels, Copper to copper alloy welding, dipped galvanised steel, Excellent corrosion resistance and electrical conductivity. Porosity free welding Joints. Free flowing alloy.

Specification:

DIN :- 1736 - SG Ni Cu 30 Mn Ti
 AWS :- SFA 5.14 - ER Ni Cu 7

Alloy Basis:

Cu – balance.	Ni – 62% max	Mn – 3% to 4%	Fe – 1.5% max	Ti – 1.5 to 3%
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Melting Range :-

1310 °C To 1350 °C

Properties:-

Applicable Gas - Argon + Co2 + O2
 Argon + Co2
 Argon
 Tensile strength - 500 N/ mm²
 Elongation - 35 %

Packing Standard:-

Size Ø - 1.6 mm, 2.0 mm, 2.5 mm, 3.15 mm, 4.0 mm.
 Length - 1000 mm
 Standard Packing - 5 kg per packet, 20 kg per case.
 Spool - MIG Welding 0.8 mm,1.2 mm,1.6 mm 12.5 kg per spool

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