

MONEL[®] Filler Metal 60

MONEL Filler Metal 60 is used for gas-tungsten-arc, gas-metal-arc, and submerged-arc welding of MONEL alloys 400, R404, and K-500. It is also used for surfacing of steel by the gas-metal-arc or submerged-arc processes. For certain gas-metal-arc conditions, a barrier layer of Nickel Filler Metal 61 is recommended. Submerged-arc welding with MONEL Filler Metal 60 is done with INCOFLUX 5 Submerged Arc Flux.

Weld metal deposited by MONEL Filler Metal 60 has properties similar to those of MONEL alloy 400. It has good strength and resists corrosion in many media, including sea water, salts, and reducing acids. The weld metal is not age hardenable and when used to join MONEL alloy K-500 has lower strength than the base metal.

Specifications

AWS A5.14 ERNiCu-7 (UNS N04060)

ASME II, Part C, SFA-5.14, ERNiCu-7 (UNS N04060)

ASME IX, F-No.42

*BS 2901 (NA33)

*DIN 1736 SG-NiCu30MnTi (2.4377)

*(EN) ISO 18274 – SNi4060 (NiCu30Mn3Ti)

*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), MIL and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

VdTUV 2114.01; 2165.01

Other approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition	Ni+Co..... 62.0-69.0		Cu Remainder	
	C..... 0.15 max.		Al 1.25 max.	
Mn..... 4.0 max.		Ti 1.5-3.0		
Fe..... 2.5 max.		P..... 0.020 max.		
S 0.015 max.		Others 0.50 max.		
Si 1.25 max.				

Minimum Mechanical Properties	Tensile Strength, psi		70,000
		MPa	483
	Elongation, (4d) %		30

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

Available Product Forms

mm in	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125
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Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)