COR™NICKEL ENiCu-7 FC

DESCRIPTION
COR-NICKEL™ ENiCu-7 FC is a flux-cored, copper-enriched nickel base alloy specifically designed to combat corrosion. It can be used for joining dissimilar alloys, and surfacing steel.

APPLICATIONS
ENiCu-7 finds specific use as a welded overlay and joining alloy for resistance to corrosion from brackish water and reducing acids. Dissimilar joining applications include nickel-copper alloys, carbon steel, low alloy steel, MONEL® 400, R-405, and K-500, and copper alloys.

PROCEDURE
Preheat according to the base material: 350°F for low alloy steels; 600°F minimum for heat treatable steels. Apply ENiCu-7 with stringer beads or a slight weave. Mild steel bases do not require post-weld heat treatment. Temper according to the base material if it is a heat treatable steel. The weld metal is suitable for service both in the as-welded condition and after an appropriate postweld heat treatment.

WELDING PARAMETERS

<table>
<thead>
<tr>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Stickout</th>
<th>Shielding Gas</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/16”</td>
<td>22-30</td>
<td>200-300</td>
<td>5/8”</td>
<td>75Ar-25CO₂</td>
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</tbody>
</table>

MECHANICAL PROPERTIES

- Tensile Strength: 70,000 psi minimum
- Elongation: 30% minimum

CLASSIFICATION
AWS A5.11, class ENiCu-7

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