

MIGWELD NiCu

MIG/MAG Wires [GMAW]

Low alloyed steel

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14341-A : G 46 2 M21Z AWS A-5.18 : ER 80S-G		Constructions & Engineering

- Solid welding wire with the addition of Ni and Cu for welding CORTEN type steels, resistant for weather and atmospheric conditions.

Application

It is used in the welding of steel structures, boilers and pressure vessels, gas pipes and turbine rotors.

Base material

DIN	EN 10088-1/2
StE 255 - StE460, WStE 255 - WStE 460	S255N-S460N, P255NH - P460NH, S275ML, S355M - S420M
StE 320.7 - StE 415.7, StE 360.7TM - StE 480.7TM X52, X56, X60, X65	L320-L415NB, L360MB - L485MB
15Mo3, 17Mn4, 19Mn6, 22Mo4, 20MnMoNi55	16Mo3, P295GH, P310GH
St35.8 - St45.8	P235G1TH - P255G1TH
GS-45, GS-52, GS-60	GE240, GE260, GE300, G20Mo5
17MnMoV6-4, 15NiCuMoNb5	20MnMoNi4-5
Special construction steels	
WT St37, WT St52	
CORTEN A, B, C	
Patinax 37, Alcodur 50, Koralpin 52	
RBH 35	
Acor 37, Acor 50	
HSB 37, HSB 55C	
S235JRW, S235J2G3Cu, S355J2G3Cu	
ASTM A36; A283 GR.BC	

Typical chemical composition %

C	Si	Mn	Cr	Ni	Cu
0,07	0,75	1,40	0,30	0,75	0,35

Typical mechanical properties

Yield strength Re [N/mm2]	>460
Tensile strength Rm [N/mm2]	530-680
Elongation A5 [%]	20
Impact energy Kv [J]	>47J (-20°C) / >47J (+20°C) /
Wire/rod type	solid
Welding current	



Welding gas acc. to EN ISO 14175

C1 - 100% CO₂ / M21 - Ar + 15 - 25% CO₂ /

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
1,0	80-95	17-19 short arc	15,0
1,0	240-270	24-27 spray arc	15,0
1,2	110-130	18-20 short arc	15,0
1,2	270-320	27-32 spray arc	15,0

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl