

## MT-NiCu 1

Copper-nickel-containing steel MIG-wire for welding weatherproof steels and cold-tough fine grain structural steels. Weld metal suitable for working temperatures from -46°C up to +300°C.

### Standard designation

AWS/ASME SFA-5.28	~ ER 80 S-Ni 1
EN ISO 14341-A	G/W 50 4 M Z

### Main base metals

S235J2W to S355J2G1W, Corten A, B, C

### Mechanical properties of all – weld – metal

(typical values)

Gas shield			M 21 untreated +20°C	M 21 untreated -30°C
Thermal treatment				
Test temperature		[°C]		
Yielding point	R <sub>eH</sub>	MPa	>500	
Tensile strength	R <sub>m</sub>	MPa	560-720	
Elongation	A <sub>5</sub>	[%]	>18	
Impact strength	A <sub>v</sub>	[J]		>47

### Average chemical composition of all-weld-metal (%)

C	Si	Mn	Cu	Ni
0,08	0,8	1,4	0,4	0,8

### Approvals

TÜV, DB, CE

### Gas types applicable TIG

I1

### Gas types applicable MIG

M 21

### TIG rod diameters available, unit weights

Diameter [mm]	Length [mm]	kgs per box
1,60	1000	25,0
2,00	1000	25,0
2,40	1000	25,0
3,20	1000	25,0

### MIG welding wire

Diameter                      0,8mm                      1,0mm                      1,2mm

### Welding positions MIG acc.to EN ISO 6947

PA, PB, PF, PC, PG

### Welding positions TIG acc.to EN ISO 6947

PA, PB, PF, PC, PG

### Current/Polarity TIG

= -

### Current/Polarity MIG

= +