


Technical data sheet <small>150222JIMBA</small>	Cored welding wire GAMMA 400	
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CLASSIFICATION

AWS A5.34 / A5.34 M: ENiCu7T0-4 ¹
 EN ISO 12153: T Z Ni 4060 (NiCu30Mn3Ti) B M21 3

¹ Classification pending. The deposit is close to the composition of the ENiCu-7 nickel-based SMAW electrodes but with increased titanium to suppress porosity.

DESCRIPTION

- Flux cored nickel base wire for gas shielded arc welding
- 65% Ni-30% Cu weld metal based on alloy 400
- Latest generation basic slag quality guarantees optimum metallurgical quality and attractive welder appeal
- Produced from a fully matching strip composition
- Deoxidation system designed to eliminate porosity and hot cracking
- Automatic slag release leaving a clean weld surface
- Good wetting with the base metal

APPLICATIONS

GAMMA 400 is specially designed for cladding and weld overlay. A full NiCu-7 composition is achieved in two layers. GAMMA 400 is also suitable for welding nickel copper alloys of similar analysis and for heterogeneous welds between alloy 400 and other alloys or steels

Examples:

Alloy	UNS	EN Designation	Material Number
400	N04400	NiCu30Fe	2.4360
405	N04405	LC-NiCu30Fe	2.4361
	N05500	G-NiCu30Nb	2.4365
K500	N65500	NiCu30Al	2.4375

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Ni	Cu	Ti	Fe	Al	S	P
0.05	3.5	0.4	63	30	2.0	1.0	0.07	0.005	0.001

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
480	200	27	+20°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
520	330	35	+20°C: 75

SHIELDING GAS

EN ISO 14175: M21 (Ar + 15% < CO₂ ≤ 25%)

OPERATING CONDITIONS

Current type	Wire feed speed	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow rate [l/min]
DC+	7 – 10 m/min.	150 - 220	24 - 30	12 - 15	12 - 20

WELDING POSITIONS

Flat, Horizontal

PACKAGING

Diameter	1.2 mm
Spool type	EN ISO 544 – ASME IIC SFA-5.2 M BS300
Weight	15 kg

Other packaging and other diameters: please consult us

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