

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	Thermal treatment	Test temperature	[°C]	M 21 untreated +20°C	M 21 untreated -30°C
Yielding point	R _{eH}	MPa		>500	
Tensile strength	R _m	MPa		560-720	
Elongation	A ₅	[%]		>18	
Impact strength	A _v	[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 Gas types applicable MIG

I1
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 Welding positions TIG acc.to EN ISO 6947

PA, PB, PF, PC, PG
PA, PB, PF, PC, PG

Current/Polarity TIG

= -

Current/Polarity MIG

= +