



COR-MET, INC.  
12500 GRAND RIVER ROAD  
BRIGHTON, MI 48116-8326  
(810) 227-3251  
800-848-2719  
FAX: (810) 227-9266  
[www.cor-met.com](http://www.cor-met.com)

## 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

---

Size	Volts	Amps	Stickout	Shielding Gas
1/16"	22-30	200-300	5/8"	75Ar-25CO <sub>2</sub>

### MECHANICAL PROPERTIES

---

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

### CLASSIFICATION

---

AWS A5.11, class ENiCu-7

MONEL is a registered trademark of INCO International.