



# DAIKOSTRIP 413

SAW

COPPER ALLOYS

CuNi 70-30

## PRODUCT DESCRIPTION

**Strip designed for submerged-arc strip cladding of 70Cu 30Ni Alloy.**

This strip is used for multilayer cladding. In case of cladding on C-steel, a buffer layer with DAIKOSTRIP 418 is necessary.

## SPECIFICATIONS

AWS A5.7	EQCuNi
EN ISO	-
DIN	-
Approvals	-
Shielding	DAIKOFLUX , 937AS

## ASME IX QUALIFICATION

F-No (QW432)	34
A-No (QW442)	-

## FERRITE

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## PREN

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## HARDNESS

100 HB

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## Typical strip analysis

Cr	Mn	Si	Ti	Ni	Cu	Fe
0.025	0.8	0.10	0.3	31.0	Bal.	0.7

## Typical weld metal analysis of strip/flux combination (weight%)

Alloy	Layer	Strip	C	Mn	Si	Cu	Ni	Fe	Ti	Thickn. (mm)
70Cu 30Ni	-	DAIKOSTRIP 418	0.020	3.5	0.2	29.4	bal.	0.3	2.3	-
	1	layer	0.04	2.7	1.0	24	bal.	16.0	0.4	5
	-	DAIKOSTRIP 413	0.025	0.8	0.10	Bal.	30.7	0.7	0.3	-
	2	Layer	0.03	1.0	0.40	bal.	38	5.0	0.25	4.7
	3	layer	0.02	0.9	0.30	bal.	32	2.0	0.2	4.7