WASHINGTON ALLOY'S Quality Management System is Certified to ***ISO 9001:2008***
Cert # 05-R0925

Ni-60
Welding Wire and Rod

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com

American Welding Society Sustaining Company Member

GAWDA GASES AND WELDING DISTRIBUTORS ASSOCIATION

ALLOY DESCRIPTION AND APPLICATION;

Washington Alloy 60 is primarily designed for MIG, TIG and submerged arc welding of nickel-copper (Monel®) alloys 400, 404 and K 500 to themselves or to each other. Washington Alloy 60 is also used for dissimilar applications such as joining nickel-copper (Monel®) alloys to nickel base alloy 200 and for joining nickel-copper (Monel®) alloys 400 and 404 or nickel base alloy 200 to copper-nickel and copper alloys. Note: When overlaying on steel, use Washington Alloy 61 for the first layer may be require for the best results. Welding on Monel 400 you can see matching properties, however when welding K-500 the filler has a lower tensile and will not age harden as this base metal.

TYPICAL GMAW WELDING PROCEDURES; DCEP Spray Arc

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stick-out	Argon (cfh)
0.030	550-750	175-250	26-32	3/8-1/2”	30-40
0.035	425-575	175-300	26-32	3/8-1/2”	30-40
0.045	250-350	200-310	26-32	3/8-1/2”	35-50
0.062	125-200	250-330	27-33	1/2"-5/8”	35-50

TYPICAL GMAW WELDING PROCEDURES; DCEP Short Circuit

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stick-out	(cfh) 75Ar/25He
0.035	150-200	90-110	19-21	3/8-1/2”	35-45
0.045	175-225	100-140	22-24	3/8-1/2”	40-50

TYPICAL GTAW WELDING PROCEDURES; DCEN with EWTh-2 truncated conical tip

Filler Wire Size	Tungsten	Amps	Volts	Gas Cup Size	Argon (cfh)	Base thickness
1/16”	1/16”	80-150	12	1/2”	20	1/16-1/8”
3/32”	3/32”	150-250	12	3/4”	25	1/8- 3/16”
1/8”	1/8”	200-375	12	5/8”	30	1/4-1/2”

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

all single values are maximum percentages

Nickel	62.0-69.0	Carbon	0.15	Copper	Balance
Manganese	4.0	Phosphorus	0.02	Silicon	1.25
Sulfur	0.015	Iron	2.5	Titanium	1.5- 3.0
		Alumnium	1.25		

Tensile Strength (psi) 74,800 Yield Strength (psi) 52,200 Elongation 32%

AVAILABLE SIZES: TN 60 = Spools of 035, 045,
Cut lengths of 035, 045, 1/16, 3/32, 1/8, 5/32

SPECIFICATIONS; **ANSI/AWS** A5.14 ERNiCu-7
ASME SFA 5.14 ERNiCu-7 F No, 42

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