

MIG & TIG

Oxford Alloy® 60

AWS ERNiCu-7 • Nickel
Alloys

Key Features

- ❖ Is used for the welding of Monel® alloys 400, R-405, and K-500.
- ❖ The weld metal deposit of Oxford Alloy 60 has properties similar to Monel® 400.
- ❖ It has good strength and resists corrosion in many medias, including seawater, salts, and reducing acids.

Conformances

AWS/ASME SFA 5.14

ERNiCu-7

UNS N04060

Chemical Composition - As required per AWS 5.14

Ni	C	Mn	Fe	Si	Cu	Al
62.0-69.0	0.15 max	4.0 max	2.5 max	1.25 max	Bal	1.25 max
Ti	P	S	OET			
1.5-3.0	0.02 max	0.015 max	0.50 max			

Mechanical Properties - As required by AWS 5.14

	Tensile Strength MPa (ksi)	Yield Strength MPa (ksi)	Elongation %
AWS Requirements	480 (70) typical	Not Specified	Not Specified
Typical Results - As welded	530 (77)	360 (53)	34



Diameter		Typical Welding Parameters			
in	(mm)	Process	Volt	Amps	Shielding Gas
.035	0.9	GMAW	26-29	150-190	Spray Transfer 100% Argon
.045	1.2	GMAW	28-32	180-220	
1/16	1.6	GMAW	29-33	200-250	
1/16	1.6	GTAW	14-18	90-130	100% Argon
3/32	2.4	GTAW	15-20	120-175	100% Argon
1/8	3.2	GTAW	15-20	150-220	100% Argon

Diameters & Packaging					
Oxford Alloys USA			Oxford Alloys Asia Pacific		
Diameter (in)	Form	Packaging (lbs)	Diameter (mm)	Form	Packaging (kgs)
.035	GMAW	33 lb spool 1980 lb pallet	0.9	GMAW	15 kg spool 900 kg pallet
.045	GMAW	33 lb spool 1980 lb pallet	1.2	GMAW	15 kg spool 900 kg pallet
1/16	GMAW	33 lb spool 1980 lb pallet	1.6	GMAW	15 kg spool 900 kg pallet
1/16	GTAW	10 lb tube 40 lb carton	1.6	GTAW	5 kg tube 20 kg carton
3/32	GTAW	10 lb tube 40 lb carton	2.4	GTAW	5 kg tube 20 kg carton
1/8	GTAW	10 lb tube 40 lb carton	3.2	GTAW	5 kg tube 20 kg carton

Actual test results may vary. Refer test result disclaimer on page 160.