

ST-400

2020.04



❖ Specification

AWS A5.14

ERNiCu-7

JIS

Z3334 S Ni4060 (NiCu30Mn3Ti)

EN

ISO 18274 S Ni 4060

❖ Applications

TIG

❖ Characteristics on Usage

No Preheat required, maximum interpass temperature 150°C and no PWHT required

❖ Note on Usage

Use 100% Ar, Ar + He

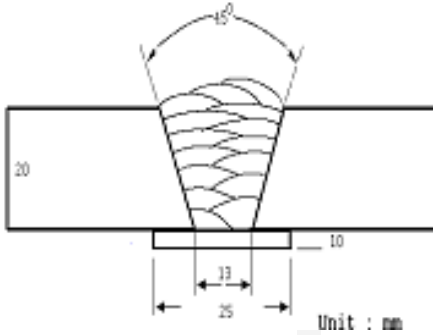
❖ Packing

Dia.	2.0mm (5/64in)	2.4mm (3/32in)	3.2mm (1/8in)
TIG	5kg (11lbs)		



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



[Joint Preparation & Layer Details]

Diameter(mm)	: 2.4mm
Shielding Gas	: 100%Ar
Flow Rate(ℓ /min.)	: 20~25
Amp./ Volt.	: 110 / 12
Pre-Heat(℃)	: R.T.
Interpass Temp.(℃)	: 150 ± 15
Polarity	: DC(-)

❖ Mechanical Properties of All weld metal

Consumable	Tensile Test		CVN Impact test Joule (ft · lbs)	
	T.S. MPa (ksi)	EL. (%)	-60℃ (-76°F)	-196℃ (-321°F)
ST-400	533 (77)	45	195 (144)	175 (129)

❖ Chemical Analysis of the wire(wt%)

Consumable	Chemical Composition (wt%)									
	C	Si	Mn	P	S	Ni	Ti	Al	Fe	Cu
ST-400	0.07	0.26	3.4	0.001	0.001	65.3	2.1	0.1	0.2	28.2
AWS A5.14 ERNiCu-7	≤0.15	≤1.25	≤4.0	≤0.02	≤0.015	62.0 ~69.0	1.5 ~3.0	≤1.25	≤2.5	Rem

❖ Chemical Analysis of All weld metal(wt%)

Consumable	Chemical Composition (wt%)									
	C	Si	Mn	P	S	Ni	Ti	Al	Fe	Cu
ST-400	0.03	0.05	3.3	0.007	0.003	59.9	1.7	0.1	6.7	27.7

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