

KANTHAL

**Alloys for Thermocouples, Extension and
Compensating Cables**

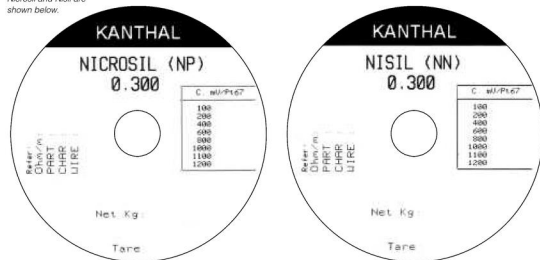


Standard E.M.F. against Pt 67- Nisil Leg (Negative)

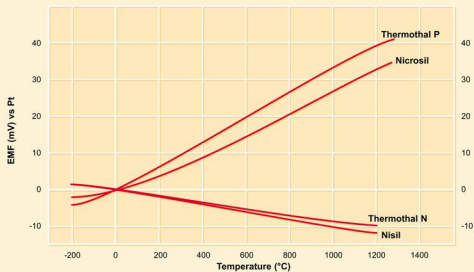
Temp. °C	0	100	200	300	400	500	600	700	800	900	1000	1100	1200	1300
E.m.f(mV)	0.000	0.990	1.970	2.993	4.055	5.145	6.243	8.325	8.360	9.327	10.210	11.004	11.702	12.292

Reference junction °C.

The labels used to identify
Nicrosil and Nisil are
shown below.



EMF Comparison of Nicrosil, Nisil, Thermothal P and N versus Pt.



Thermocouple Thermothal P / Thermothal N (Type K)

Type K thermocouples find widest use at temperatures above 500 °C due to their strong resistance to oxidation better than other basemetal thermocouples.

Thermothal P / Thermothal N thermocouples cover all the specifications required by international norms.

Each thermocouple element is manufactured so as to meet special tolerances when matched to platinum; this enables any coil of Thermothal P to be matched with any coil of Thermothal N to form the standard tolerance. Each coil is tested at 200 °C - 400 °C - 600 °C - 800 °C - 1000 °C against platinum 67 and each one is provided with a tag which gives the emf values against Pt 67.

The following table lists KP/KN emf characteristics against Pt 67 (NIST Monograph 175).

Precautions in the use of Type K

Indications are given below regarding the precautions to be taken when using type K couples. These are listed in ASTM STP 470A:

Type K Thermocouples have a better resistance to oxidation than other combinations, except type N, and are recommended for oxidising or inert atmospheres.

Thermocouple type K cannot be used directly or without protection in the following cases:

- Alternatively oxidising and reducing atmospheres.
- Atmospheres with sulphur containing gases. The alloys are attacked causing intergranular corrosion, embrittlement and cracking of the negative leg (Thermothal N).
- Any protection sheaths should be cleaned to remove oils, fats, carbon containing substances, dirt.
- In a vacuum, except for a short time, chromium evaporates mostly from the positive leg Thermothal P, causing the emf of the couple to alter.
- Reducing atmospheres such as hydrogen, dissociated ammonia or carbon monoxide which has a low oxygen content.

Thermothal P (KP) / Thermothal N (KN) E.M.F. Reference Table (mV) Reference Junction 0 °C

°C	0	10	20	30	40	50	60	70	80	90	100
0	0.000	0.397	0.798	1.203	1.612	2.023	2.437	2.851	3.267	3.682	4.096
100	4.096	4.509	4.920	5.328	5.735	6.138	6.540	6.941	7.340	7.739	8.139
200	8.139	8.539	8.940	9.343	9.747	10.153	10.561	10.971	11.382	11.795	12.209
300	12.209	12.624	13.040	13.457	13.875	14.293	14.713	15.133	15.554	15.975	16.397
400	16.397	16.820	17.243	17.667	18.091	18.516	18.941	19.366	19.792	20.218	20.644
500	20.644	21.071	21.497	21.924	22.350	22.776	23.203	23.629	24.055	24.480	24.906
600	24.906	25.330	25.755	26.179	26.602	27.025	27.447	27.869	28.290	28.710	29.129
700	29.129	29.548	29.965	30.382	30.798	31.214	31.628	32.041	32.453	32.865	33.275
800	33.275	33.685	34.093	34.501	34.908	35.313	35.718	36.121	36.524	36.925	37.326
900	37.326	37.726	38.124	38.522	38.918	39.314	39.708	40.102	40.494	40.885	41.276
1000	41.276	41.665	42.053	42.440	42.826	43.211	43.595	43.978	44.359	44.740	45.119
1100	45.119	45.497	45.873	46.2491	46.623	46.996	47.367	47.737	48.105	48.473	48.839

Standard E.M.F. against Pt 67 - Thermothal P (KP) Leg (Positive)

Temp. °C	0	100	200	300	400	500	600	700	800	900	1000	1100	1200
E.m.f (mV)	0	2.814	5.970	9.323	12.764	16.214	19.618	22.951	26.205	29.386	32.499	35.544	38.508

Standard E.M.F. against Pt 67- Thermothal N (KN) Leg (Negative)

Temp. °C	0	100	200	300	400	500	600	700	800	900	1000	1100	1200
E.m.f (mV)	0	1.283	2.168	2.886	3.633	4.431	5.287	6.178	7.070	7.940	8.777	9.575	10.330

In reducing atmospheres, the positive leg (90% Nickel - 10% Chromium) develops green oxide called "Green rot" (Cr_2O_3) instead of the Nickel-Chromium oxide ($\text{NiO} - \text{Cr}_2\text{O}_3$). The development of the green oxide decreases the Chromium content in Thermothal P. This causes a reduction of its emf, resulting in reduction in emf output by up to 55 %

particularly in the range 816 °C to 1038 °C. This condition is accompanied by the KP arm becoming magnetic due to loss of chromium.

By use of suitable sheath material, the corrosive gases can be prevented from attacking the thermocouple. Sheaths with too small a diameter should be avoided.

The labels used to identify Thermothal P and Thermothal N are shown below.



5 Thermocouple Thermothal P (EP)/Cuprothal (EN) (Type E)

Type E has the largest emf output of any common thermocouple and is sometimes used in thermal-generators (thermopiles). It is used up to 900 °C and has good stability from the cryogenic range up to

300 °C. The positive arm of the couple is Thermothal P, the same as type K thermocouple, the negative arm is Cuprothal (EN).

Thermothal P (EP)/Cuprothal (EN) E.M.F. Reference Table (mV) - Reference Junction 0 °C

°C	0	10	20	30	40	50	60	70	80	90	100
0	0.000	0.591	1.192	1.801	2.420	3.048	3.685	4.330	4.985	5.648	6.319
100	6.319	6.998	7.685	8.379	9.081	9.789	10.504	11.224	11.951	12.684	13.421
200	13.421	14.164	14.9121	15.664	16.420	17.181	17.945	18.713	19.484	20.257	21.036
300	21.036	21.817	22.6001	23.386	24.174	24.964	25.757	26.552	27.348	28.146	28.946
400	28.946	29.747	30.550	31.354	32.159	32.965	33.772	34.579	35.388	36.196	37.005
500	37.005	37.815	38.624	39.434	40.244	41.053	41.862	42.671	43.479	44.286	45.093
600	45.093	45.900	46.705	47.510	48.313	49.116	49.917	50.718	51.517	52.315	53.112
700	53.112	53.908	54.703	55.497	56.289	57.080	57.870	58.659	59.446	60.232	61.017
800	61.017	61.801	62.583	63.364	64.144	64.922	65.698	66.473	67.246	68.017	68.787
900	68.787	69.554	70.319	71.083	71.844	72.603	73.360	74.115	74.869	75.621	76.373

Standard E.M.F. against Pt 67 (mV) - Cuprothal (EN)

Temp. °C	0	100	200	300	400	500	600	700	800	900
mV	0	3.505	7.451	11.713	16.182	20.792	25.475	30.161	34.812	39.401

The labels used to identify Thermothal P and Cuprothal (EN) are shown below.



Thermocouple Copper/Cuprothal (TN) (Type T)

The combination of Copper (as a positive element) and Cuprothal (TN) (as a negative element) gives rise to a thermocouple that finds use both in the laboratory and in industry over the temperature range -185 °C to +370 °C. It is advisable not to go beyond this temperature because of the limited resistance of copper to oxidation. Normally we only supply the negative element (Cuprothal (TN)) since any good, pure electrolytic copper (e.g. conforming to ASTM Norm B3) is sufficiently uniform and constant in emf from one batch to another, especially at temperatures above -185 °C.

It should be remembered that the negative element of the Thermocouple P (EP)-Cuprothal (EN) and Copper-Cuprothal (TN) do not give the same emf output as Iron (JP)-Cuprothal (JN) and for this reason Cuprothal (EN) and Cuprothal (TN) are not interchangeable with Cuprothal (JN).

The emf-temperature characteristics of Copper/Cuprothal (TN) thermocouples are listed below. If material is required for use at sub zero temperatures it is essential to state this at the time of ordering as a special quality of Cuprothal has to be selected.

Copper - Cuprothal (TN) E.M.F. Reference Table (mV) - Reference Junction 0 °C

°C	0	10	20	30	40	50	60	70	80	90	100
-200	-5.603	-5.439	-5.261	-5.070	-4.865	-4.6481	-4.4191	-4.1771	-3.923	-3.657	-3.379
-100	-3.379	-3.089	-2.788	-2.476	-2.153	-1.819	-1.475	-1.121	-0.757	-0.383	0.000
0	0.000	0.391	0.789	1.196	1.612	2.036	2.468	2.909	3.358	3.814	4.279
100	4.279	4.750	5.228	5.714	6.206	6.704	7.209	7.720	8.235	8.760	9.288
200	9.288	9.822	10.362	10.908	11.458	12.013	12.574	13.139	13.709	14.283	14.862
300	14.8621	15.445	16.032	16.624	17.219	17.819	18.422	19.030	19.6411	20.255	20.872

For tolerances please see table on the following pages.

Standard E.M.F. against Pt 67 (mV) Copper Leg (Positive)

Temp. °C	-200	-100	0	100	200	300	400
mV	-0.195	-0.369	0	0.773	1.837	3.149	4.690

The label used to identify Cuprothal (TN) is shown below.



Standard E.M.F. against Pt 67 (mV) Cuprothal (TN) Leg (Negative)

Temp. °C	-200	-100	0	100	200	300	400
mV	-5.408	-3.010	0	3.505	7.451	11.713	16.182

7 Thermocouple Iron (JP)/Cuprothal (JN) (Type J)

This thermocouple is frequently used because of its high emf and its low cost. It can be used in oxidising conditions up to 760 °C or reducing conditions up to 900 °C approx. We recommend the use of larger wire diameters with higher temperatures. It has also to be taken into consideration that a magnetic transformation occurs in the iron at 770 °C and a crystallographic change at 900 °C.

This affects the thermoelectric characteristics of Iron quite markedly.

Type J thermocouples must not be used in sulphurous atmospheres above 500 °C and, due to embrittlement, they are not recommended at temperatures below zero.

Only a small amount of the world production of iron wire is allocated for use in thermocouples and the producers of iron are therefore not interested in controlling melts to an emf value.

Therefore, on the basis of the iron available, it is necessary to select suitable melts of Cuprothal that, coupled to the iron, follow the standardization curves with the respective tolerances. Kanthal supplies the special iron for J thermocouples. It should be remembered that Cuprothal (JN) is not interchangeable with Cuprothal (TN) and with Cuprothal (EN), nor can it be used with other kinds of iron.

Iron (JP) / Cuprothal (JN) E.M.F. Reference Table (mV) - Reference Junction 0 °C

°C	0	10	20	30	40	50	60	70	80	90	100
0	0.000	0.507	1.019	1.537	2.059	2.585	3.116	3.650	4.187	4.727	5.269
100	5.269	5.814	6.360	6.909	7.459	8.010	8.562	9.115	9.669	10.224	10.779
200	10.779	11.334	11.889	12.445	13.000	13.555	14.110	14.665	15.219	15.773	16.327
300	16.327	16.881	17.434	17.986	18.539	19.091	19.642	20.194	20.745	21.297	21.848
400	21.848	22.400	22.952	23.504	24.057	24.610	25.164	25.720	26.276	26.834	27.393
500	27.393	27.953	28.516	29.080	29.647	30.216	30.788	31.362	31.939	32.519	33.102
600	33.102	33.689	34.279	34.873	35.470	36.071	36.675	37.284	37.896	38.512	39.132
700	39.132	39.755	40.382	41.012	41.645	42.281	42.919	43.559	44.203	44.848	45.494
800	45.494	46.141	46.786	47.431	48.074	48.715	49.353	49.989	50.622	51.251	51.877

For tolerances see tables on the following pages.

On request, Kanthal can supply Cuprothal (LN) that, combined with Iron (LP), meets the old German specification DIN 43710 for type L thermocouples.

The labels used to identify Iron (JP) and Cuprothal (JN) are shown below.



Cuprothal CL

Cuprothal CL has a very high emf value against Pt67, the highest among the different types of Cuprothal. This property comes from the low content of additional elements in its chemical composition. On the contrary, in the other types of Cuprothal, some additions are necessary to meet the emf values requested by the norms. Due to this characteristic of having a high thermoelectric output, Cuprothal CL is used mostly in the manufacture of thermocouples to detect the presence of the flame in gas burners, connected to safety devices.

Cuprothal CL - E.M.F. Minimum Values (mV) against Pt 67.

E.M.F. testing must be carried out on annealed material. Reference junction at 0 °C.

Temperature (°C)	E.M.F. (mV) min.
0	0
100	4.00
200	8.62
800	38.68

Delivery Form

The wire is normally supplied in coils, in the half-hard condition, with a tensile strength ranging between 600 and 800 MPa.

The labels used to identify Cuprothal CL are shown below.



E.M.F Tolerances

Unless otherwise specified thermocouples, compensating and extension materials are supplied to "standard" tolerances.

On request, material can be supplied with special tolerances. Each spool and coil has been calibrated in a temperature range between 0 °C and the maximum temperature value indicated for each alloy combination (max.temperature 1000 °C, 1100 °C on request).

Standard and special tolerances are detailed in the tables below.

As can be seen, different tolerances are applied in the temperature range below 0 °C. If the material has to be used below 0 °C, this must be requested at the time of ordering, as special material has to be selected.

American Specifications ASTM E230- ANSI MC 96.1

Type of thermocouple	Temperature range °C	Tolerance		
		Standard	Special	Standard
Thermothal P (KP) / Thermothal N (KN) (Type K) Thermothal P (EP) / Cuprothal (EN) (Type E) Copper / Cuprothal (TN) (Type T) Iron (JP) / Cuprothal (JN) (Type J) Nicrosil (NP) / Nisil (NN) (Type N)	from 0 to 1250 from 0 to 900 from 0 to 350 from 0 to 750 from 0 to 1300	$\pm 2.2\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$ $\pm 1.7\text{ }^{\circ}\text{C}$ or $\pm 0.5\%$ $\pm 1\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$ $\pm 2.2\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$ $\pm 2.2\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$		
Thermothal P (KP) / Thermothal N (KN) (Type K) Thermothal P (EP) / Cuprothal (EN) (Type E) Copper / Cuprothal (TN) (Type T) Iron (JP) / Cuprothal (JN) (Type J) Nicrosil (NP) / Nisil (NN) (Type N)	from 0 to 1250 from 0 to 900 from 0 to 350 from 0 to 750 from 0 to 1300	- - - - -	$\pm 1.1\text{ }^{\circ}\text{C}$ or $\pm 0.4\%$ $\pm 1\text{ }^{\circ}\text{C}$ or $\pm 0.4\%$ $\pm 0.5\text{ }^{\circ}\text{C}$ or $\pm 0.4\%$ $\pm 1.1\text{ }^{\circ}\text{C}$ or $\pm 0.4\%$ $\pm 1.1\text{ }^{\circ}\text{C}$ or $\pm 0.4\%$	
Thermothal P (KP) / Thermothal N (KN) (Type K) Thermothal P (EP) / Cuprothal (EN) (Type E) Copper / Cuprothal (TN) (Type T) Iron (JP) / Cuprothal (JN) (Type J) Nicrosil / Nisil (Type N)	from -200 to 0 from -200 to 0 from -200 to 0 - - -	- - - - - -	- - - - - -	$\pm 2.2\text{ }^{\circ}\text{C}$ or $\pm 2\%$ $\pm 1.7\text{ }^{\circ}\text{C}$ or $\pm 1\%$ $\pm 1\text{ }^{\circ}\text{C}$ or $\pm 1.5\%$ - -

European Specifications IEC 584-2 (DIN EN 60584-2 ; BS EN 60584-2 ; JIS C 1602)

Type de thermocouple	Gamme de température	Tolérances		
		Classe 1	Classe 2	Classe 3 (1)
Thermothal P (KP) / Thermothal N (KN) (Type K) Thermothal P (EP) / Cuprothal (EN) (Type E) Copper / Cuprothal (TN) (Type T) Iron (JP) / Cuprothal (JN) (Type J) Nicrosil (NP) / Nisil (NN) (Type N)	from -40 to 1000 from -40 to 800 from -40 to 350 from -40 to 750 from -40 to 1000	$\pm 1.5\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$ $\pm 1.5\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$ $\pm 0.5\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$ $\pm 1.5\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$ $\pm 1.5\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$	- - - - -	- - - - -
Thermothal P (KP) / Thermothal N (KN) (Type K) Thermothal P (EP) / Cuprothal (EN) (Type E) Copper / Cuprothal (TN) (Type T) Iron (JP) / Cuprothal (JN) (Type J) Nicrosil (NP) / Nisil (NN) (Type N)	from -40 to 1200 from -40 to 900 from -40 to 350 from -40 to 750 from -40 to 1200	- - - - -	$\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$ $\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$ $\pm 1\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$ $\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$ $\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$	- - - - -
Thermothal P (KP) / Thermothal N (KN) (Type K) Thermothal P (EP) / Cuprothal (EN) (Type E) Copper / Cuprothal (TN) (Type T) Iron (JP) / Cuprothal (JN) (Type J) Nicrosil / Nisil (Type N)	from -40 to +40 from -40 to +40 from -40 to +40 - - from -200 to +40	- - - - - -	- - - - - -	$\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 1.5\%$ $\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 1.5\%$ $\pm 1\text{ }^{\circ}\text{C}$ or $\pm 1.5\%$ - - $\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 1.5\%$

The tolerance is whichever is the greater value.

French Specification NF EN 60584-2

Type of thermocouple	Temperature range °C	Tolerance		
		Class 1	Class 2	Class 3 (1)
Thermothal P (KP) / Thermothal N (KN) (Type K)	from - 40 to 1000	$\pm 1.5\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$	-	-
Thermothal P (EP) / Cuprothal (EN) (Type E)	from - 40 to 800	$\pm 1.5\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$	-	-
Copper / Cuprothal (TN) (Type T)	from - 40 to 750	$\pm 1.5\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$	-	-
Iron (JP) / Cuprothal (JN) (Type J)	from - 40 to 350	$\pm 0.5\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$	-	-
Nicrosil (NP) / Nisil (NN) (Type N)	from - 40 to 1000	$\pm 1.5\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$	-	-
Thermothal P (KP) / Thermothal N (KN) (Type K)	from - 40 to 1200	-	$\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$	-
Thermothal P (EP) / Cuprothal (EN) (Type E)	from - 40 to 900	-	$\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$	-
Copper / Cuprothal (TN) (Type T)	from - 40 to 750	-	$\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$	-
Iron (JP) / Cuprothal (JP) (Type J)	from - 40 to 350	-	$\pm 1\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$	-
Nicrosil (NP) / Nisil (NN) (Type N)	from - 40 to 1200	-	$\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$	-
Thermothal P (KP) / Thermothal N (KN) (Type K)	from - 200 to + 40	-	-	$\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 1.5\%$
Thermothal P (EP) / Cuprothal (EN) (Type E)	from - 200 to + 40	-	-	$\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 1.5\%$
Copper / Cuprothal (TN) (Type T)	-	-	-	-
Iron (JP) / Cuprothal (JN) (Type J)	from - 200 to + 40	-	-	$\pm 1\text{ }^{\circ}\text{C}$ or $\pm 1.5\%$
Nicrosil/Nisil (Type N)	from - 200 to + 40	-	-	$\pm 2.5\text{ }^{\circ}\text{C}$ or $\pm 1.5\%$

Italian Specification UNI 7938

Type of thermocouple	Temperature range °C	Tolerance		
		G 1	G 2	
Thermothal P (KP) / Thermothal N (KN) (Type K)	from 0 to 1250	$\pm 1.1\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$	$\pm 2.2\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$	
Thermothal P (EP) / Cuprothal (EN) (Type E)	from 0 to 900	$\pm 1\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$	$\pm 1.7\text{ }^{\circ}\text{C}$ or $\pm 0.50\%$	
Copper / Cuprothal (TN) (Type T)	from 0 to 750	$\pm 1.1\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$	$\pm 2.2\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$	
Iron (JP) / Cuprothal (JN) (Type J)	from 0 to 350	$\pm 0.5\text{ }^{\circ}\text{C}$ or $\pm 0.40\%$	$\pm 1\text{ }^{\circ}\text{C}$ or $\pm 0.75\%$	
Nicrosil (NP) / Nisil (NN) (Type N)	from - 200 to 0	-	$\pm 2.2\text{ }^{\circ}\text{C}$ or $\pm 2\%$	
Thermothal P (KP) / Thermothal N (KN) (Type K)	from - 200 to 0	-	$\pm 1.7\text{ }^{\circ}\text{C}$ or $\pm 1.5\%$	
Thermothal P (EP) / Cuprothal (EN) (Type E)	-	-	-	
Copper / Cuprothal (TN) (Type T)	from - 200 to 0	-	$\pm 1\text{ }^{\circ}\text{C}$ or $\pm 1.5\%$	
Iron (JP) / Cuprothal (JP) (Type J)	-	-	-	-
Nicrosil (NP) / Nisil (NN) (Type N)	-	-	-	-
Thermothal P (KP) / Thermothal N (KN) (Type K)	-	-	-	-
Thermothal P (EP) / Cuprothal (EN) (Type E)	-	-	-	-
Copper / Cuprothal (TN) (Type T)	-	-	-	-
Iron (JP) / Cuprothal (JN) (Type J)	-	-	-	-
Nicrosil/Nisil (Type N)	-	-	-	-

(1) Thermocouple materials are normally supplied to meet the tolerances specified in the table for temperatures above $-40\text{ }^{\circ}\text{C}$. These materials, however, may not fall within the tolerances given for low temperatures under class 3 for types T, E, K and N.

If thermocouples are required to meet the limits of class 3, as well as those of class 1 or 2, the purchaser needs to state this, as selection of materials is usually required.

The tolerance is whichever is the greater value.

10 Formation of the Hot Junction

To form the hot junction, a suitable method has to be adopted to obtain a good electrical contact between the thermocouple wires.

At low temperatures, where generally Copper/Cuprothal (TN) couples are used, soft or silver soldering can be adopted.

For Thermothal P/Thermothal N and other combinations, for use in high temperature measurements, welding is the only method to obtain a suitable joint.

For this purpose oxy-acetylene welding is mostly used, but arc welding also gives good results.

Oxy-Acetylene and gas welding

The wire ends have to be cleaned by filing or grinding and twisted together with two or three turns as shown in the picture 11.6.

This procedure provides a good contact during welding and prevents any tension in the welded joint. The wires are held vertically in a vice and the flame positioned downwards on to the twisted wires for welding.

A good weld is formed by a small drop fusing the wires together at the twisted end. The size of the gas flame must be altered depending upon the wire diameter and it is necessary to use a neutral or reducing flame. Overheating should be avoided as this may cause embrittlement of the wires.

With experience, satisfactory welding can be achieved without the use of a flux but if difficulty occurs then borax can be used. Remember that it should be totally cleaned from the metal after the weld has cooled down.

Rewelding is difficult. If the weld is inadequate it is usually necessary to cut the wires and start a new weld.

Arc welding

The wires are cleaned and twisted as in gas welding and are then held in a vice which is connected to a +VE arm of a d.c. supply. A carbon electrode as the -VE leg is then touched on the twisted wires just sufficiently to create an arc and weld the wires at the end. The required voltage depends upon the wire diameter but for 3.2 mm diameter a voltage of about 40V is required. No flux is required in this type of welding.

When the carbon electrode is replaced by a Tungsten electrode, we have a TIG (Tungsten Inert Gas) weld which is also very common for welding thermocouple materials. In this case, a stream of inert gas is blown on to the welding joint to provide full protection against air contamination.

Discharge capacity welding

This method of welding is adopted for small diameter wires (up to 0.8 mm).

The ends of the thermoelement have to be cleaned with emery paper and the wires are held in contact as shown in picture 11.7.

Picture 11.6



Picture 11.7



11 Thermocouple Compensating and Extension Grade Alloys

When connecting thermocouples to instruments, it is essential that a cable is used which has the same emf output as the thermocouple, otherwise spurious emf is generated at these junctions. The best solution is to use the same material as the thermocouple (extension cable). The tolerances for these are listed in the following tables.

A cheaper alternative is to use compensating cables, the alloys of which are different from those of the thermocouple but have the same output over a limited temperature range.

An example of this is in the use of Copper/Cuprothal (VNX) Type KCB (VX) cable for use with Thermathal P/Thermathal N (Type K) thermocouples.

Our Cuprothal SX alloy (SNCB/RNCB, SNX/RNX) is used with copper for the compensation of Pt/PtRh thermocouples (S & R).

Compensating and extension grades of wire are supplied in the bright annealed condition.

The following is a list of the principal Kanthal Compensating and Extension Cables.

American Specification ANSI MC96-1

Thermocouple	Compensating or extension cables	Nominal composition of the cable	American Specification ANSI MC 96-1			
			mV	at temp	Tolerance	
					Standard	Special
Thermathal P (KP) / Thermathal N (KN) (Type K)	Thermathal P (KPX) / Thermathal N (KNX) (KX)	Thermathal P (KPX): 90% Ni - 10% Cr Thermathal N (KNX): 95% Ni-Mn-Si	4.096 8.139	100 °C 200 °C	± 2.2 °C from 0° C to 200 °C	
Thermathal P (KP) / Thermathal N (KN) (Type K)	Cu / Cuprothal (VNX) (VX)*	Cu: 100% Cu Cuprothal (VNX): 44% Ni Balance Cu	4.096 -	100 °C	± 2.2 °C from 0° to 100 °C	
Thermathal P (EP) / Cuprothal (EN) (Type E)	Thermathal P (EPX) - Cuprothal (ENX) (EX)	Thermathal P (EPX): 90% Ni-10% Cr Cuprothal (ENX): 44% Ni Balance Cu	6.319 13.421	100 °C 200 °C	± 1.7 °C from 0° to 200 °C	
Cu/Cuprothal (TN) (Type T)	Cu - Cuprothal (TNX) (TX)	Cu: 100% Cu Cuprothal (TNX): 44% Ni Balance Cu	- 4.279	0 °C 100 °C	± 1 °C from 0° to 100 °C	± 0.5 °C from 0° to 100 °C
Iron (JP) / Cuprothal (JN) (Type J)	Iron (JFX) / Cuprothal (JNX) (JX)	Iron (JFX): 100% Fe Cuprothal (JNX): 44% Ni Balance Cu	5.269 10.779	100 °C 200 °C	± 2.2 °C from 0° to 200 °C	± 1.1 °C from 0° to 200 °C
Pt/Pt 10% Rh Pt/Pt 13% Rh (Type S, R)	Cu/Cuprothal SX (SX) (RX)	Cu: 100% Cu Cuprothal SX: 3% Ni-Mn-Balance Cu	0.646 1.441	100 °C 200 °C	± 0.057 mV from 0° to 200 °C	
Nicrosil (NP) / Nisil (NN) (Type N)	Nicrosil (NPX) / Nisil (NXX) (NX)	Nicrosil (NPX): 84% Ni - 14.2% Cr-Si Nisil (NXX): 95% Ni - 4.30% Si	2.774 5.913	100 °C 200 °C	± 2.2 °C from 0° to 200 °C	

*Type VX is not included in the recent American specification but it is still used.

European Specification IEC 584-3 (DIN EN 60584-3; BS 4937; NFC 42324)

Thermocouple	Compensating or extension cables	Nominal composition of the cable	European Spec IEC 584-3			
			mV	at temp.	Tolerance	
					Class 2	Class 1
Thermothal P (KP) / Thermothal N (KN) (Type K)	Thermothal P (KPX) - Thermothal N (KNX) (KK)	Thermothal P (KPX) : 90% Ni - 10% Cr Thermothal N (KNX) : 95% Ni-Al-Mn-Si	4.096	100 °C	± 2.5 °C	± 1.5 °C
			8.139	200 °C	from -25° to 200 °C	from -25° to 200 °C
Thermothal P (KP) / Thermothal N (KN) (Type K)	Iron (WPX) - Cuprothal WX (WNX) (KCA)	Iron (WPX) : 100% Fe Cuprothal WX (WNX) : 43% Ni - 2% Mn 2% Fe - Balance Cu	4.096	100 °C	± 2.5 °C	
			8.139	200 °C	from 0° to 150 °C	
Thermothal P (KP) / Thermothal N (KN) (Type K)	Cu - Cuprothal (VNX) (KCB)	Cu : 100% Cu Cuprothal (VNX) : 44% Ni Balance Cu	4.096	100 °C	± 2.5 °C	
			-	-	from 0° to 100 °C	
Thermothal P (EP) / Cuprothal (EN) (Type E)	Thermothal P (EPX) - Cuprothal (ENX) (EX)	Thermothal P (EPX) : 90% Ni - 10% Cr Cuprothal (ENX) : 44% Ni Balance Cu	6.319	100 °C	± 2.5 °C	± 1.5 °C
			13.421	200 °C	from -25° to 200 °C	from -25° to 200 °C
Cu/Cuprothal (TN) (Type T)	Cu - Cuprothal (TNX) (TX)	Cu : 100% Cu Cuprothal (TNX) : 44% Ni Balance Cu	4.279	100 °C	± 1 °C	± 0.5 °C
			-	-	from -25° to 100° C	from -25° to 100 °C
Iron (JP) /Cuprothal (JN) (Type J)	Iron (JFX) - Cuprothal (JNX) (JX)	Iron (JFX) : 100% Fe Cuprothal (JNX) : 44% Ni Balance Cu	5.269	100 °C	± 2.5 °C	± 1.5 °C
			10.779	200 °C	from -25° to 200 °C	from -25° to 200 °C
Pt/Pt 10% Rh Pt/Pt 13% Rh (Type S, R)	Cu - Cuprothal SX RCA - SCA RCB - SCB	Cu : 100% Cu Cuprothal SX : 3% Ni-Mn-Balance Cu	-	-	-	-
			0.646	100 °C	± 2.5 °C	-
			-	-	from 0° to 100 °C	-
			0.646	100 °C	± 5 °C	-
Nicrosil (NP) / Nisil (NN) (Type N)	Nicrosil (NPX) - Nisil (NNX) (NX)	Nicrosil (NPX) : 84% Ni - 14.2% Cr-Si Nisil (NNX) : 95% Ni - 4.3% Si	2.774	100 °C	± 2.5 °C	± 1.5 °C
			5.913	200 °C	from -25° to 200 °C	from -25° to 200 °C
Nicrosil (NP) / Nisil (NN) (Type N)	Cu - Cuprothal NX (NNX) (NC)	Cu : 100% Cu Cuprothal NX (NNX) : 41% Ni - 2%Mn - 2% Fe Balance Cu	2.774	100 °C	± 2.5 °C	
			5.913	200 °C	from 0° to 150 °C	

Italian Specification UNI 7938

Thermocouple	Compensating or extension cables	Nominal composition of the cable	Italian Specification UNI 7938			
			mV	at temp.	Tolerance	
					Standard G2	Special G1
Thermothal P (KP) / Thermothal N (KN) (Type K)	Thermothal P (KPX) / Thermothal N (KNX) (KX)	Thermothal P (KPX): 90% Ni - 10% Cr Thermothal N (KNX): 95% Ni+Al-Mn-Si	4.095	100 °C	± 2.2 °C	-
			8.137	200 °C	from 20° to 205 °C	-
Thermothal P (KP) / Thermothal N (KN) (Type K)	Iron (WPX) - Cuprothal WX (WNX) (WX)	Iron (WPX): 100% Fe Cuprothal WX (WNX): 43% Ni - 2% Mn 2% Fe - Balance Cu	4.095	100 °C	± 3.3 °C	-
			8.137	200 °C	from 25° to 205 °C	-
Thermothal P (KP) / Thermothal N (KN) (Type K)	Cu-Cuprothal (VNX) (VX)	Cu: 100% Cu Cuprothal (VNX): 44% Ni Balance Cu	-	-	-	-
			-	-	-	-
Thermothal P (EP) / Cuprothal (EN) (Type E)	Thermothal P (EPX) - Cuprothal (ENX) (EX)	Thermothal P (EPX): 90% Ni - 10% Cr Cuprothal (ENX): 44% Ni Balance Cu	6.317	100 °C	± 1.6 °C	-
			13.419	200 °C	from 20° to 205 °C	-
Cu/Cuprothal (TN) (Type T)	Cu - Cuprothal (TNX) (TX)	Cu: 100% Cu Cuprothal (TNX): 44% Ni Balance Cu	-2.152	- 60 °C	± 0.8 °C	± 0.4 °C
			4.277	+100 °C	from 60° to 95 °C	from 60° to 95 °C
Iron (JP) / Cuprothal (JN) (Type J)	Iron (JPX) - Cuprothal (JNX) (JX)	Iron (JPX): 100% Fe Cuprothal (JNX): 44% Ni Balance Cu	5.268	100 °C	± 2.2 °C	± 1.1 °C
			10.777	200 °C	from 20° to 205 °C	from 20° to 205 °C
Pt/Pt 10% Rh Pt/Pt 13% Rh (Type S, R)	Cu - Cuprothal SX (SX) (RX)	Cu: 100% Cu Cuprothal SX: 3% Ni-Mn-Bal. Cu	0.645	100 °C	± 6.7 °C	-
			1.440	200 °C	from 25° to 205 °C	-

Japanese Specification JIS C 1610

Thermocouple	Compensating or extension cables	Nominal composition of the cable	Japanese Specification JIS C 1610			
			mV	at temp	Tolerance	
					Class 2	Class 1
Thermothal P (KP) / Thermothal N (KN) (Type K)	Thermothal P (KPX) / Thermothal N (KNX) (KX)	Thermothal P (KPX): 90% Ni - 10% Cr Thermothal N (KNX): 95% Ni + Al-Mn-Si	4.096 8.139	100 °C 200 °C	± 100 µV from -25° to 200 °C	± 60 µV from -25° to 200 °C
Thermothal P (KP) / Thermothal N (KN) (Type K)	Iron (WPX) / Cuprothal WX (WXX) (KCS)	Iron (WPX): 100% Fe Cuprothal WX (WXX): 43% Ni - 2% Mn 2% Fe - Balance Cu	4.096 8.139	100 °C 200 °C	± 100 µV from 0° to 150 °C	- -
Thermothal P (KP) / Thermothal N (KN) (Type K)	Cu - Cuprothal (VXX) (KCC)	Cu: 100% Cu Cuprothal (VXX): 44% Ni Balance Cu	4.096 -	100 °C -	± 100 µV from 0° to 100 °C	- -
Thermothal P (EP) / Cuprothal (EN) (Type E)	Thermothal P (EPX) / Cuprothal (ENX) (EX)	Thermothal P (EPX): 90% Ni - 10% Cr Cuprothal (ENX): 44% Ni Balance Cu	6.319 13.421	100 °C 200 °C	± 200 µV from -25° to 200 °C	± 120 µV from -25° to 200 °C
Cu/Cuprothal (TN) (Type T)	Cu - Cuprothal (TX) (TX)	Cu: 100% Cu Cuprothal (TX): 44% Ni Balance Cu	4.279 -	100 °C -	± 60 µV from -25° to 100 °C	± 30 µV from -25° to 100 °C
Iron (JP) / Cuprothal (JN) (Type J)	Iron (JFX) / Cuprothal (JNX) (JX)	Iron (JFX): 100% Fe Cuprothal (JNX): 44% Ni Balance Cu	5.269 10.779	100 °C 200 °C	± 140 µV from -25° to 200 °C	± 85 µV from -25° to 200 °C
Pt-Pt 10% Rh Pt-Pt 13% Rh (Type S, R)	Cu - Cuprothal SX RCA - SCA RCB - SCB	Cu: 100% Cu Cuprothal SX: 3% Ni-Mn Balance Cu	- 0.646 -	- 100 °C -	- ± 30 µV from 0° to 100 °C	- -
			0.646 1.441	100 °C 200 °C	± 60 µV from 0° to 200 °C	- -
Nicrosil (NP)/Nisil (NN) (Type N)	Nicrosil (NPX) / Nisil (NNX) (NX)	Nicrosil (NPX): 84% Ni - 14.2% Cr-Si Nisil (NNX): 95% Ni - 4.3% Si	2.774 5.913	100°C 200 °C	± 100 µV from -25° to 200 °C	± 60 µV from -25° to 200 °C
Nicrosil (NP)/Nisil (NN) (Type N)	Cu - Cuprothal NX (NNX) (NC)	Cu: 100% Cu Cuprothal NX (NNX): 41% Ni-2% Mn-2% Fe Balance Cu	2.774 5.913	100 °C 200 °C	± 100 µV from 0° to 150 °C	

Tables

Thermothal P Wire

B&S or AWG				SWG				Metric					
B&S or AWG	Diam. mm	Length m/kg	Weight g/m	SWG	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m
6	4.115	8.62	116.0	8	4.064	8.84	113.1	10.00	1.46	684.9	1.20	101	9.86
7	3.658	10.91	91.64	9	3.658	10.91	91.64	8.00	2.28	438.3	1.15	110	9.06
8	3.251	13.82	72.38	10	3.251	13.82	72.38	7.00	2.98	335.6	1.13	114	8.75
10	2.591	21.75	45.98	12	2.642	20.92	47.80	6.00	4.06	246.6	1.00	146	6.85
12	2.057	34.51	28.98	14	2.032	35.36	28.28	4.70	6.61	151.3	0.81	223	4.49
14	1.626	55.23	18.11	16	1.626	55.23	18.11	4.00	9.13	109.6	0.64	356	2.81
16	1.295	87.07	11.49	18	1.219	98.26	10.18	3.90	9.60	104.2	0.63	368	2.72
18	1.016	141	7.07	19	1.016	141	7.07	3.26	13.74	72.8	0.60	406	2.47
20	0.813	221	4.53	20	0.914	175	5.72	3.20	14.26	70.1	0.51	561	1.78
22	0.643	353	2.83	21	0.813	221	4.53	3.00	16.22	61.6	0.50	584	1.71
24	0.511	559	1.79	22	0.711	289	3.46	2.50	23.36	42.8	0.45	721	1.39
25	0.455	705	1.418	24	0.559	467	2.14	2.30	27.60	36.2	0.40	913	1.10
26	0.404	895	1.12	26	0.457	699	1.43	2.05	34.74	28.8	0.32	1426	0.70
28	0.320	1426	0.70	30	0.315	1472	0.68	2.00	36.50	27.4	0.30	1622	0.62
32	0.203	3543	0.28	34	0.234	2667	0.38	1.63	54.96	18.2	0.25	2336	0.43
36	0.127	9053	0.11	36	0.193	3920	0.26	1.50	64.89	15.4	0.20	3650	0.27
								1.40	74.50	13.41	0.18	4507	0.22
								1.29	87.74	11.41	0.10	14601	0.07

Thermothal N Wire

B&S or AWG				SWG				Metric					
B&S or AWG	Diam. mm	Length m/kg	Weight g/m	SWG	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m
6	4.115	8.7	114.4	8	4.064	8.96	111.6	10.00	1.48	675.4	1.20	103	9.73
7	3.658	11.1	90.38	9	3.658	11.06	90.38	8.00	2.31	432.3	1.15	112	8.93
8	3.251	14.0	71.39	10	3.251	14.01	71.39	7.00	3.02	331.0	1.13	116	8.62
10	2.591	22.1	45.34	12	2.642	21.21	47.15	6.00	4.11	243.2	1.00	148	6.75
12	2.057	35.0	28.58	14	2.032	35.86	27.89	4.70	6.70	149.2	0.81	226	4.43
14	1.626	56.0	17.86	16	1.626	56.00	17.86	4.00	9.25	108.1	0.64	361	2.77
16	1.295	88.3	11.33	18	1.219	99.63	10.04	3.90	9.73	102.7	0.63	373	2.68
18	1.016	143	6.97	19	1.016	143	6.97	3.26	13.93	71.78	0.60	411	2.43
20	0.813	224	4.46	20	0.914	177	5.64	3.20	14.46	69.17	0.51	569	1.76
22	0.643	353	2.79	21	0.813	224	4.46	3.00	16.45	60.79	0.50	592	1.69
24	0.511	567	1.76	22	0.711	293	3.41	2.50	23.69	42.22	0.45	731	1.37
25	0.455	715	1.36	24	0.559	474	2.11	2.30	27.99	35.73	0.40	925	1.08
26	0.404	907	1.10	26	0.457	709	1.41	2.05	35.23	28.39	0.32	1446	0.69
28	0.320	1446	0.69	30	0.315	1492	0.67	2.00	37.01	27.02	0.30	1645	0.61
32	0.203	3593	0.28	34	0.234	2704	0.37	1.63	55.72	17.95	0.26	2369	0.42
36	0.127	9179	0.11	36	0.193	3975	0.25	1.50	65.80	15.20	0.20	3701	0.27
								1.40	75.54	13.24	0.18	4569	0.22
								1.29	88.97	11.24	0.10	14805	

Cuprothal (JN), Cuprothal (EN), Cuprothal (TN), Cuprothal WX, Cuprothal NX Wires

B&S or AWG				SWG				Metric					
B&S or AWG	Diam. mm	Length m/kg	Weight g/m	SWG	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m
6	4.115	8.4	118.4	8	4.064	8.66	115.4	10.00	1.43	699.0	1.20	99	10.07
7	3.658	10.7	93.53	9	3.658	10.69	93.53	8.00	2.24	447.4	1.16	108	9.24
8	3.251	13.5	73.88	10	3.251	13.54	73.88	7.00	2.92	342.5	1.13	112	8.93
10	2.591	21.3	46.93	12	2.642	20.50	48.79	6.00	3.97	251.6	1.00	143	6.99
12	2.057	33.8	29.58	14	2.032	34.65	28.86	4.70	6.48	154.4	0.81	218	4.59
14	1.626	54.1	18.48	16	1.626	54.11	18.48	4.00	8.94	111.8	0.64	349	2.86
16	1.295	85.3	11.72	18	1.219	96.27	10.39	3.90	9.41	106.3	0.63	360	2.77
18	1.016	139	7.22	19	1.016	138.6	7.22	3.26	13.46	74.29	0.60	397	2.52
20	0.813	216	4.62	20	0.914	171.2	5.84	3.20	13.97	71.58	0.51	550	1.82
22	0.643	346	2.89	21	0.813	216.4	4.62	3.00	15.90	62.91	0.50	572	1.75
24	0.511	548	1.83	22	0.711	283.0	3.53	2.50	22.89	43.69	0.45	707	1.42
25	0.455	691	1.45	24	0.559	457.8	2.18	2.30	27.04	36.98	0.40	894	1.12
26	0.404	877	1.14	26	0.457	685	1.46	2.05	34.04	29.38	0.32	1397	0.72
28	0.320	1397	0.72	30	0.315	1442	0.69	2.00	35.77	27.96	0.30	1590	0.63
32	0.203	3472	0.29	34	0.234	2613	0.38	1.63	53.84	18.57	0.25	2289	0.44
36	0.127	8870	0.11	36	0.193	3841	0.26	1.50	63.58	15.73	0.20	3577	0.28
								1.40	72.99	13.70	0.18	4415	0.23
								1.29	85.97	11.63	0.10	14306	0.07

Iron Wire

B&S or AWG				SWG				Metric					
B&S or AWG	Diam. mm	Length m/kg	Weight g/m	SWG	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m
6	4.115	9.57	104.51	8	4.064	9.8	102.0	10.00	1.62	617.3	1.20	112	8.89
7	3.658	12.11	82.60	9	3.658	12.1	82.60	8.00	2.53	395.1	1.16	122	8.16
8	3.251	15.33	65.24	10	3.251	15.3	65.24	7.00	3.31	302.5	1.13	127	7.88
10	2.591	24.13	41.44	12	2.642	23.2	43.09	6.00	4.50	222.2	1.00	162	6.17
12	2.057	38.28	26.12	14	2.032	39.2	25.49	4.70	7.33	136.4	0.81	247	4.05
14	1.626	61.27	16.32	16	1.626	61.3	16.32	4.00	10.12	98.77	0.64	395	2.53
16	1.295	96.59	10.35	18	1.219	109	9.17	3.90	10.65	93.89	0.63	408	2.45
18	1.016	157	6.37	19	1.016	157	6.37	3.26	15.24	65.61	0.60	450	2.22
20	0.813	245	4.08	20	0.914	194	5.16	3.20	15.82	63.21	0.51	623	1.61
22	0.643	392	2.55	21	0.813	245	4.08	3.00	18.00	55.56	0.50	648	1.54
24	0.511	620	1.61	22	0.711	320	3.12	2.50	25.92	38.58	0.45	800	1.25
25	0.455	783	1.28	24	0.559	518	1.93	2.30	30.62	32.66	0.40	1012	0.99
26	0.404	992	1.01	26	0.457	776	1.29	2.05	38.55	25.94	0.32	1582	0.63
28	0.320	1582	0.63	30	0.315	1633	0.61	2.00	40.50	24.69	0.30	1800	0.56
32	0.203	3931	0.25	34	0.234	2958	0.34	1.63	60.97	16.40	0.25	2592	0.39
36	0.127	10043	0.10	36	0.193	4349	0.23	1.50	72.00	13.89	0.20	4050	0.25
								1.40	82.65	12.10	0.18	5000	0.20
								1.29	97.34	10.27	0.10	16199	0.06

Cuprothal SX Wire

B&S or AWG				SWG				Metric					
B&S or AWG	Diam. mm	Length m/kg	Weight g/m	SWG	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m
6	4.115	8.4	118.5	8	4.06	8.7	115.6	10.00	1.43	699.8	1.20	99	10.08
7	3.658	10.7	93.64	9	3.658	10.7	93.64	8.00	2.23	447.9	1.15	108	9.25
8	3.251	13.5	73.96	10	3.251	13.5	73.96	7.00	2.92	342.9	1.13	112	8.94
10	2.591	21.3	46.98	12	2.642	20.5	48.85	6.00	3.97	251.9	1.00	143	7.00
12	2.057	33.8	29.61	14	2.032	34.6	28.89	4.70	6.47	154.6	0.81	218	4.59
14	1.626	54.0	18.50	16	1.626	54.0	18.50	4.00	8.93	112.0	0.64	349	2.87
16	1.295	85.2	11.74	18	1.219	96	10.40	3.90	9.40	106.4	0.63	360	2.78
18	1.016	138	7.22	19	1.016	138	7.22	3.26	13.45	74.37	0.60	397	2.52
20	0.813	216	4.63	20	0.914	171	5.85	3.20	13.96	71.66	0.51	549	1.82
22	0.643	346	2.89	21	0.813	216	4.63	3.00	15.88	62.98	0.50	572	1.75
24	0.511	547	1.83	22	0.711	283	3.54	2.50	22.86	43.74	0.45	706	1.42
25	0.455	690	1.45	24	0.559	457	2.19	2.30	27.01	37.02	0.40	893	1.12
26	0.404	876	1.14	26	0.457	684	1.46	2.05	34.00	29.41	0.32	1396	0.72
28	0.320	1390	0.72	30	0.315	1440	0.69	2.00	35.73	27.99	0.30	1588	0.63
32	0.203	3468	0.29	34	0.234	2610	0.38	1.63	53.78	18.59	0.25	2286	0.44
36	0.127	8860	0.11	36	0.193	3836	0.26	1.50	63.51	15.75	0.20	3573	0.28
								1.40	72.91	13.72	0.18	4410	0.23
								1.29	85.87	11.65	0.10	14290	0.07

Nicrosil Wire

B&S or AWG				SWG				Metric					
B&S or AWG	Diam. mm	Length m/kg	Weight g/m	SWG	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m
6	4.115	8.8	113.4	8	4.064	9.0	110.6	10.00	1.49	669.9	1.20	104	9.65
7	3.658	11.2	89.65	9	3.658	11.2	89.65	8.00	2.33	428.8	1.15	113	8.86
8	3.251	14.1	70.81	10	3.251	14.1	70.81	7.00	3.05	328.3	1.13	117	8.55
10	2.591	22.2	44.98	12	2.642	21.4	46.76	6.00	4.15	241.2	1.00	149	6.70
12	2.057	35.3	28.35	14	2.032	36.2	27.66	4.70	6.76	148.0	0.81	228	4.40
14	1.626	56.5	17.71	16	1.626	56.5	17.71	4.00	9.33	107.2	0.64	364	2.74
16	1.295	89.0	11.24	18	1.219	100	9.96	3.90	9.81	101.9	0.63	376	2.66
18	1.016	145	6.92	19	1.016	145	6.92	3.26	14.05	71.20	0.60	415	2.41
20	0.813	226	4.43	20	0.914	179	5.60	3.20	14.58	68.60	0.51	574	1.74
22	0.643	361	2.77	21	0.813	226	4.43	3.00	16.59	60.30	0.50	597	1.67
24	0.511	572	1.75	22	0.711	295	3.39	2.50	23.88	41.87	0.45	737	1.36
25	0.455	721	1.39	24	0.559	478	2.09	2.30	28.22	35.44	0.40	933	1.07
26	0.404	915	1.09	26	0.457	715	1.40	2.06	35.52	28.15	0.32	1458	0.69
28	0.320	1458	0.69	30	0.315	1504	0.66	2.00	37.32	26.80	0.30	1659	0.60
32	0.203	3622	0.28	34	0.234	2726	0.37	1.63	56.18	17.80	0.25	2388	0.42
36	0.127	9255	0.11	36	0.193	4007	0.25	1.50	66.34	15.07	0.20	3732	0.27
								1.40	76.16	13.13	0.18	4607	0.22
								1.29	89.70	11.15	0.10	14927	0.07

Nisil Wire

B&S or AWG				SWG				Metric					
B&S or AWG	Diam. mm	Length m/kg	Weight g/m	SWG	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m	Diam. mm	Length m/kg	Weight g/m
6	4.115	8.8	114.1	8	4.064	9.0	111.3	10.00	1.48	673.9	1.20	103	9.70
7	3.658	11.1	90.17	9	3.658	11.1	90.17	8.00	2.32	431.3	1.16	112	8.91
8	3.251	14.0	71.22	10	3.251	14.0	71.22	7.00	3.03	330.2	1.13	116	8.60
10	2.591	22.1	45.24	12	2.642	21.3	47.04	6.00	4.12	242.6	1.00	148	6.74
12	2.057	35.1	28.51	14	2.032	35.9	27.82	4.70	6.72	148.9	0.81	226	4.42
14	1.626	56.1	17.82	16	1.626	56.1	17.82	4.00	9.27	107.8	0.64	362	2.76
16	1.295	88.5	11.30	18	1.219	100	10.01	3.90	9.76	102.5	0.63	374	2.67
18	1.016	144	6.96	19	1.016	144	6.96	3.26	13.96	71.62	0.60	412	2.43
20	0.813	225	4.45	20	0.914	178	5.63	3.20	14.49	69.00	0.51	571	1.75
22	0.643	359	2.79	21	0.813	225	4.45	3.00	16.49	60.65	0.50	594	1.68
24	0.511	568	1.76	22	0.711	294	3.41	2.50	23.74	42.12	0.45	733	1.37
25	0.455	717	1.40	24	0.559	475	2.11	2.30	28.05	35.65	0.40	927	1.08
26	0.404	909	1.10	26	0.457	711	1.41	2.05	35.31	28.32	0.32	1449	0.69
28	0.320	1449	0.69	30	0.315	1496	0.67	2.00	37.10	26.95	0.30	1649	0.61
32	0.203	3601	0.28	34	0.234	2710	0.37	1.63	55.85	17.90	0.25	2374	0.42
36	0.127	9201	0.11	36	0.193	3984	0.25	1.60	65.95	15.16	0.20	3710	0.27
								1.40	75.71	13.21	0.18	4580	0.22
								1.29	89.18	11.21	0.10	14840	0.07

13 Delivery Forms

Packaging

Kanthal materials are normally packed as described to the right. In case, wire can also be specially packed to individual requirements, if possible. If additional protection is required, spools are wrapped with plastic film.

Wire - up to approximately 1.40 mm diameter is available on spools as the table shows.

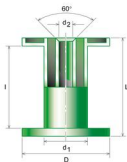
Wire of 1.50 mm and up to 6 mm diameter is supplied in coils with an inside diameter from 350 to 450 mm depending on the alloy type and diameter size. Wire of 2 mm and up to 6 mm can be straightened in half-hard condition, 3 m lengths, if requested. Wire bigger than 6 mm and up to 10 mm can be supplied only in oxidised or straightened form. Straight lengths are supplied in bundles.

Ribbon - up to 6 mm width is normally supplied on DIN spools.

Strips - from 6 mm to 60 mm width are supplied in coils.

Rods - Available in pickled or shaved condition depending on the alloy.

In order to avoid transport damage all goods are carefully packed in card board boxes or wooden cases, with suitable internal protection.



Spool Designation	Diameter mm	Nominal Wire Weight Kg	D mm	d1 mm	d2 mm	L mm	I mm	Tare g
DIN 500	0.80 - 1.40	90	500	315	36	250	189	8000
DIN 355	0.50 - 1.40	40	355	224	36	200	160	1850
DIN 250	0.30 - 1.00	20	250	160	36	200	160	1050
DIN 200	0.25 - 0.80	14	200	125	36	200	160	600
DIN 160	0.20 - 0.80	7	160	100	22	160	128	350
DIN 125	0.15 - 0.80	3	125	80	16	125	100	200
DIN 100	0.10 - 0.50	1.5	100	63	16	100	80	125
DIN 80	0.04 - 0.15	0.5	80	50	16	80	64	70

14 Tolerances

Unless specified to the contrary, all wire, strip and ribbon are supplied fully annealed with either a bright, matt or oxidised finish. The type of finish should be stated when ordering.

Standard tolerances for wire, straight lengths and strip are given below.

Tolerances on Diameter of Wire.

Wire Size mm	Tolerance mm	Wire Size In.	Tolerance In.
0.10 - 0.12	± 0.004	0.0039 - 0.0047	± 0.00016
0.13 - 0.19	± 0.005	0.0048 - 0.0075	± 0.0002
0.20 - 0.31	± 0.006	0.0076 - 0.0122	± 0.00024
0.32 - 0.55	± 0.008	0.0123 - 0.0216	± 0.00031
0.56 - 0.89	± 0.010	0.0217 - 0.0350	± 0.0004
0.90 - 1.39	± 0.020	0.0351 - 0.0547	± 0.0008
1.40 - 2.10	± 0.025	0.0548 - 0.0827	± 0.0010
2.11 - 4.49	± 0.030	0.0828 - 0.1768	± 0.00118
4.50 - 9.00	± 0.040	0.1769 - 0.3543	± 0.00157

Ovality: Half the above tolerances.

Tolerances on Diameter of Straight Lengths.

Diameter mm	Tolerance mm	Diameter In.	Tolerance In.
1.7 to 3	+ 0/- 0.060	0.067 to 0.118	+ 0/-0.0024
3.01 to 6	+ 0/-0.075	0.119 to 0.236	+ 0/-0.0030
6.01 to 10	+ 0/-0.09	0.237 to 0.394	+ 0/-0.0035

Tolerances on Dimensions of Cold Rolled Strip and Ribbon.

Generally our standard size tolerance is ±5% on dimensions although we can work to tighter tolerances of ±2.5% if requested. We will of course try to meet customer's requirements if specific tolerances are required.

Tolerances on Nominal Length for cut and Straightened Lengths (Rods)

For diameters ≤ 3 mm, ± 1 mm on the length.

For diameters between 3 mm and 10 mm, -0/+4 mm.

No tolerances on electrical resistance are given for thermocouples, extension and compensating cables.

15 Standard Refractory Tubes

Al ₂ O ₃ %	Max operating temp. °C	Absorption H ₂ O in % volume	Bulk density kg/dm ³	Thermal conductivity between 20-100° Kcal/m/h/°C	Cold compression strength	Spec.heat between 100-1000° Kcal/Kg/°C	Fe ₂ O ₃ % content	Thermal shock resistance	Specification
44	1250	12-18	1.9	1.1 - 1.5	300	0.2	< 1	good	KER 530 DIN 40685
63 plates 80 tubes	1350	12-18	2.2	1.5 - 2	400	0.2	0.8	good	KER 610 slightly porous
Cordierite	1200	10-15	1.9	1.1 - 1.4	500	0.2	< 1	excellent	KER 520

The choice between refractory with standard and high Al₂O₃ content is determined by the wire alloy and by the working temperature. For Fe Cr Al alloys we suggest a Al₂O₃ content over 60%.

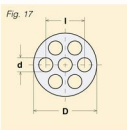
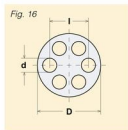
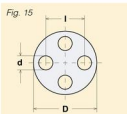
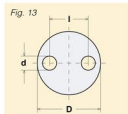
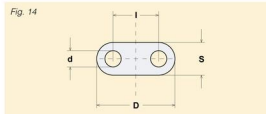
No.	FIG.	D (mm)	d (mm)	l (mm)
028	13	3	0.8	1.3
028	13	3.5	1	1.6
028	13	3.8	1.15	1.8
028	13	4	1	1.8
028	13	4	1.2	1.8
028	13	4.5	1.3	2.35
028	13	5	1.5	2.35
028	13	5	1.8	2.35
028	13	6	2	2.8
028	13	6.5	2	3.2
028	13	7	2.5	3.2
028	13	7.5	2	3.6
028	13	7.5	2.5	3.6
028	13	8	2.2	3.6
028	13	8	3	3.6
028	13	8.5	3	4.1
028	13	9	3	4.1
028	13	10	3	4.5
028	13	12	4	5.4
028	13	12	4.5	5.4
028	13	14	4	6.4
028	13	14	5	6.4
028	13	16	5	7

No.	FIG.	D (mm)	d (mm)	l (mm)	No. holes
030	15	4	0.8	2.2	4
030	15	4.5	1	2.5	4
030	15	6	1.5	3.0	4
030	15	8.5	2	4.5	4
030	15	8.5	2.5	4.7	4
030	15	8.5	1.5	4.25	4
030	15	9.5	3	5.3	4
030	15	12	3	6.5	4
030	15	12	3.5	6.7	4
030	15	13	4	7.3	4
030	15	14	4	7.7	4
030	15	16	5	9	4
030	15	16	4.5	9.5	4
030	15	17	5	10	4
030	16	5.5	1	3.4	4
030	16	8	1.6	5.1	6
030	16	10	2.2	6.5	6
030	16	14	3.5	9	6
030	16	15	3.5	9.5	6
030	17	11.5	2.7	8	7
030	17	12.4	2.7	8	7
030	17	13	3	8.5	7
030	17	14.5	2	9	7
030	17	16	4	10	7
030	17	18	4.5	11.5	7

No. DH	FIG.	D (mm)	S (mm)	d (mm)	l (mm)
029	14	3	2	0.8	1.6
029	14	4.3	3	1	1.8
029	14	12	7	4	5.5
029	14	12.7	7.21	4	5.5
029	14	15	9	4.5	7
029	14	15	9	5	7

Standard lengths:

L = 25 - 50 - 100 mm other lengths on request.



KANTHAL

**Alloys for Thermocouples, Extension and
Compensating Cables**

16 Kanthal Protection Tubes

Kanthal Metallic Protection Tubes Up to 1400 °C

These metallic protection tubes are manufactured from our high temperature resistance alloy Kanthal AF, 6.0 - 22.0 mm dia and Kanthal APM 22.0 - 40.0 mm with maximum operating temperature in air of 1400 °C.

The advantages offered by using Kanthal protection tubes for thermocouples are:

- Resistant to temperature which are 150 to 200 °C, higher than for other types of metallic protection tubes.
- High resistance to attack by sulphur or carbon compounds.
- The high temperature resistance of the material makes it possible to produce tubes with thin walls with a long service life. Thin walls gives rapid heat transmission, which means higher sensitivity to temperature variations.
- The aluminium oxide layer on the protection tube has minimal tendency to flake which means that contamination is avoided.

Kanthal Metallic Protection Tubes

Dimensions (mm) Outer diameter	Wall thickness	Max length
6.0	0.4	6000
15.0	1.3	6000
19.1	1.3	6000
22.0	1.3 or 2.0	6000
26.0	2.9	6000
33.7	3.0 or 6.0	6000
40.0	3.0	6000

Kanthal Metallic Tubes will be supplied closed in one end and provided threaded at the other end for the connection head. They can also be supplied in standard lengths up to 6 m with both ends open. OD 6-22 mm are welded, 26-40 mm extruded.

Kanthal Super Protection Tubes Up to 1700 °C

These tubes are made of molybdenum disilicide, as our Kanthal Super heating elements. Kanthal Super protection tubes have the following advantages:

- The highest operating temperature is 1700 °C.
- Porosity and brittleness are lower than for ceramic protection tubes. The tubes are thus particularly suitable for operating at high temperatures and in corrosive furnace atmospheres.
- Metallic protection tubes can under circumstances be influenced by electromagnetic oscillations which may disturb the function of the thermocouple. The Kanthal Super protection tube suppresses such oscillations.

Kanthal Super Protection Tubes

Dimension (mm) Outer diameter	Wall thickness	Max length
7.0	2.0	2000
10.0	2.0	2000
12.0	4.5	2000
12.0	3.0	2000
18.0	4.0	2000
22.0	4.5	2000
25.0	5.0	2000
32.0	7.0	1000
50.0	11.0	1000

Kanthal Super Tubes can be supplied with one end closed and also provided with a threaded tube fitting.

KANTHAL

KANTHAL AB

Box 502, SE-734 27 Hallstahammar, Sweden

Tel. +46 220 210 00 Fax +46 220 163 50

www.kanthal.com

A Sandvik Company

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7 Introduction and General Comments

The principle on which the modern thermocouple operates is derived from Seebeck's discovery that if a circuit is formed using two dissimilar metal conductors with one junction at a higher temperature than the other, then a current will flow in the circuit. The resultant emf is proportional to the temperature difference between the junctions.

For many industrial heating processes, particularly those carried out at high temperatures, a thermocouple is the most accurate, convenient and simple method of temperature measurement. In some instances, it is the only feasible method. We have been leaders in the production of a wide range of thermocouple materials for many years. Our Thermothal P and Thermothal N base metal alloys for use at temperatures up to 1260 °C, have long been specified for some of the most demanding applications - from nuclear reactors and nuclear submarines to jet aero engines and industrial furnaces. The inherent instability of NiCr/NiAl has been vastly improved by the introduction of Nicrosil/Nisil thermocouples. Other thermocouple combinations fulfil less exacting tasks with equal accuracy.

Full details of the Kanthal range of thermocouple alloys are given on the following pages. If you need technical advice or help, our accumulated knowledge and expertise in this highly specialised field is readily and freely available.

Kanthal alloys are supplied according to the following standards, shown below.

Where older standards, which are not equivalent, are still in use, we can supply different emf values at the customer's request. The equivalent Kanthal alloys and combinations are dealt under well-established trade

marks. These are itemised below, followed in each case by the relevant type code in brackets. "P" and "N" are used to indicate the positive and negative legs.

Standard Grade

This grade is calibrated throughout the entire operating temperature range and the emf of the couples complies with the relevant standards or customer specifications. Each individual arm is calibrated against Platinum and emf values are shown on the label of each coil or spool. The thermoelements of the thermocouple type J, Cuprothal (JN) and Iron (JP), are normally supplied in the bright annealed condition.

Thermothal P and Thermothal N wires (type K thermocouple) are available in the bright or oxidised condition.

Special Grade

All thermocouple combinations are available by selection to closer tolerances than normal (1/2 and 1/4 tolerances) for applications where special accuracy is required. Tolerances for Special Grade material - which carries a surcharge - are listed on following pages.

For some applications, special tolerances of ± 0.25 °C or ± 0.002 T (whichever is greater - where "T" is the temperature) can be manufactured.

Other special tolerance grades can be supplied on request.

Sheathing Grade

Where thermocouples are required for fabrication into mineral filled sheathed elements, it is necessary to select alloys to special emf requirements.

ASTM	(American Society for Testing and Materials) E230
ANSI	(American National Standard Institute) MC 96.1
IEC	(European Standard by the International Electrotechnical Commission) 584-1/2/3
DIN	(Deutsche Industrie Normen) EN 60584-1/2
BS	(British Standards) 4937-1041, EN 60584-1/2
NF	(Norme Française) EN 60584-1/2-NFC 42323-NFC 42324
UNI	(Unificazione Italiana) UNI-7938
JIS	(Japanese Industrial Standards) C1602-C 1610
GHOST	(Unification of the Russian Specifications) 3044

The wire conforms to the following international specifications:

JIS C 1605-ASTM E 608, E 585

and other main specifications.

During the production of thermocouples used in mineral filled sheathed elements, the emf value changes because of:

- **The preparation method and successive thermic treatments.**
- **The type of material of the sheath: Stainless Steel or Nickel-Chromium alloys with high temperature resistance.**
- **Insulation values.**

Kanthal produces special thermocouple wires to reduce these emf variations and to ensure the finished cable has minimum deviation from standard values.

Types of thermocouple wire

The types of thermocouple wire that Kanthal produces are shown below.

Code	Wires Component the Thermocouple	
	Positive Leg	Negative Leg
N	Nicrosil (NP)	Nisil (NN)
K	Thermothal P (KP)	Thermothal N (KN)
E	Thermothal P (EP)	Cuprothal (EN)
J	Iron (JP)	Cuprothal (JN)
T	Copper	Cuprothal (TN)

The highest stability in emf is obtained by special heat treatment for a particular application.

Calibration

All thermocouple types are calibrated to ensure that the emf is correct over the range of temperatures required by international specifications. Thermocouples required for use at sub zero temperatures must be ordered as such. All thermoelectric alloys are individually calibrated against Pt 67 and the emf values at the various temperatures are shown on the corresponding label.

Hard and half hard processing products (joints)

It is frequently necessary to manufacture joints to connect thermocouples to compensation or extension cables. For this purpose, it is preferable to use the same alloy as the thermocouple (or cable) to avoid spurious emf when the joint temperatures are different.

For machining purposes, it is often more satisfactory to use a harder temper of the alloy.

To improve workability, these materials have to be hard or half hard. Because the work hardening operation or other processing cause an emf change, the finished product must be then annealed to obtain the correct emf.

Bright annealing of Thermothal P/Thermothal N is carried out at 1100 °C for 30 minutes in a reducing atmosphere or in a vacuum. The atmosphere must be free from sulphur gases and moisture.

Cleaning and removal of oil and lubricant components before the annealing process is recommended. Calibration values of half hard or hard Kanthal products are always referred to the material in the annealed condition.

Other special features

Oxidised surface

Bright wires are easily attacked when an atmosphere of H₂S and CO₂ is present. Resistance to this corrosive attack is improved by the use of oxidised wires. In addition the wire can be protected by closed sheaths which are ventilated by pumping a small supply of clean air into a sheath which has a side vent at the cold junction end and is open at the hot junction end. Kanthal manufactures these oxidised wires to standard emf requirements or to special customer needs.

2 Thermocouples

The most used thermocouple combinations are:

Thermocouple Type	Thermo-element	Alloy	Working Atmosphere	Temperature Range °C
K	KP	Thermothal P	Oxidising	-200 +1200
	KN	Thermothal N	Inert	
E	EP	Thermothal P (EP)	Oxidising	-200 +900
	EN	Cuprothal (EN)	Inert	
T	TP	Copper	Oxidising, vacuum	-200 +350
	TN	Cuprothal (TN)	Reducing, inert	
J	JP	Iron (JP)	Oxidising (limited use at high temp)	-40 +750
	JN	Cuprothal (JN)	Reducing, inert, vacuum	
N	NP	Nicrosil	Oxidising	-200 +1200
	NN	Nisil	Inert	

Choice of Thermocouple

The thermocouple has to be chosen in relation to the temperature, working atmosphere and physical characteristics of the components.

A considerable advantage in using the thermocouple type J (Iron (JP) / Cuprothal (JN)) is its ability to work in oxidising and reducing atmospheres.

Copper coated iron can be provided to prevent corrosion during shelf life.

Type K (Thermothal P / Thermothal N) is made with two alloys of high nickel content which allows their use in both oxidising and reducing atmospheres.

Where type K is used in reducing atmospheres, it is necessary to take the precaution mentioned previously.

Thermocouple type T (Copper/Cuprothal (TN)) is mostly used at room and cryogenic temperatures.

Thermocouple type E (Thermothal P (EP)/Cuprothal (EN)) is used for applications where a high thermoelectric value is required.

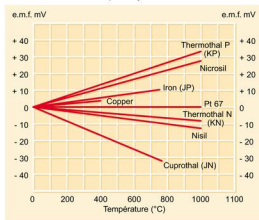
Maximum Operating Temperature

The conditions under which industrial thermocouples operate vary so widely that it is impossible to give exact values for thermocouple life.

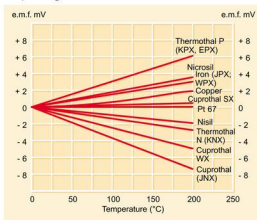
Principal factors that affect the life of a thermocouple are:

Temperature: Thermocouple life decreases by about 50% when an increase of 50 °C occurs.

Nominal EMF for Thermocouple Alloys VS Pt 67



Nominal EMF for Thermocouple Extension and Compensating Cables VS Pt 67



Diameter: By doubling the diameter of the wire, the life increases by 2-3 times.

Thermic cycling: When thermocouples are exposed to thermic cycling from room temperature to above 500 °C, their life decreases by about 50% compared to a couple used continuously at the same temperature.

Protection: When thermocouples are covered by

a protective sheath and placed into ceramic insulators, their life is considerably extended.

Below, we give the maximum temperatures recommended for thermocouples used as bare and protected wires for different diameters, working in air without cycling.

Thermocouples	Type	3.26 mm	1.63 mm	1.00 mm	0.80 mm	0.50 mm	0.30 mm	0.25 mm
Thermothal P / Thermothal N (Type K)	Bare Wire	1050 °C	930 °C	900 °C	860 °C	800 °C	750 °C	710 °C
	Protected wire	1150 °C	1080 °C	1050 °C	970 °C	910 °C	860 °C	820 °C
Thermothal P (EP) / Cuprothal (EN) (Type E)	Bare Wire	890 °C	800 °C	750 °C	700 °C	660 °C	620 °C	580 °C
	Protected wire	1000 °C	910 °C	860 °C	810 °C	770 °C	730 °C	690 °C
Copper/ Cuprothal (TN) (Type T)	Bare Wire	-	400 °C	360 °C	320 °C	280 °C	250 °C	220 °C
	Protected wire	-	450 °C	410 °C	370 °C	370 °C	330 °C	270 °C
Iron (JP) / Cuprothal (JN) (Type J)	Bare Wire	760 °C	760 °C	720 °C	680 °C	650 °C	600 °C	560 °C
	Protected wire	760 °C	760 °C	760 °C	760 °C	760 °C	710 °C	670 °C
Nicrosil / Nisil (Type N)	Bare Wire	1100 °C	1010 °C	960 °C	930 °C	890 °C	840 °C	800 °C
	Protected wire	1250 °C	1180 °C	1110 °C	1040 °C	1000 °C	950 °C	910 °C

These temperatures are given as a guide to obtain a satisfactory life before burn out of the thermocouple occurs. Checks on stability should be carried out at regular intervals.

Properties and Grades of Thermocouple and Compensating Alloys

Alloy	Nominal Composition %					Approx. Melting Point °C	Specific Resistance Microhm cm At 20°C (Indication only)	Density g/cm ³	Temperature Coefficient Of Resistance X10 ⁻⁴ /°C		Linear Expansion Coefficient X10 ⁻⁶ /°C		Thermal Conductivity Wm ⁻¹ °C ⁻¹ At 20 °C
	Ni	Cr	Fe	Cu	Other								
Thermothal P (+)	90	10	-	-	+	1430	70.6	8.72	300	20-100	17	20-100	19.2
Thermothal N (-)	95	-	-	-	AlMnSi+	1400	29.2	8.60	1900	20-100	17	20-100	29.7
Cuprothal (EN) (JN), (TN) (-)	44	-	+	Bal	Mn+	1210	49	8.90	60	20-100	14	20-100	21.2
Cuprothal WX (-)	43	-	2	Bal	Mn+	1210	52	8.90	100	20-100	15	20-100	21.0
Cuprothal SX (-)	3	-	-	Bal	2Mn	1080	12	8.91	1500	20-100	16	20-100	-
Platinum	-	-	-	-	-	1773	10.6	21.45	3000	20-100	89	20-100	69.5
Iron (+)	-	-	100	-	+	1535	13	7.86	5000	20-100	11.7	20-100	66.2
Nicrosil (+)	Bal	14.2	-	-	Si+	1420	100	8.53	90	20-100	17	20-100	13
Nisil (-)	Bal	-	-	-	4.30 Si	1420	36.5	8.58	678	20-100	17	20-100	27
Cuprothal NX (-)	44	-	+	Bal	2Mn	1210	52	8.90	100	20-100	15	20-100	21
Copper (+)	-	-	-	100	-	1083	1.72	8.92	3930	20-100	16.6	20-100	388
Cuprothal CL (-)	45	-	-	Bal	-	1210	49	8.90	100	20-100	14	20-100	21.2

Nicrosil/Nisil Thermocouple (Type N)

For many years, the Type K base metal thermocouple has been the first choice for temperature measurements up to about 1000 °C. Despite of its numerous advantages, this combination has nevertheless had certain drawbacks. A new and improved alloy combination, Nicrosil/Nisil, has therefore been developed.

Although the Type K thermocouple combines calibration accuracy, stability, oxidation resistance and high thermal emf at a reasonable price, certain operating conditions can impair its performance.

- Long exposure to high temperature may cause a gradual drift in emf.
- A short-term change in emf may occur in the 250 - 550 °C range.

In terms of its liability to emf drift and short-term emf changes, Type N is a significant improvement on the Type K combination. It also has a much longer

life, due to the improved oxidation resistance of the negative Nisil leg.

The thermal emf output for Nicrosil/Nisil is lower than for Type K, so direct substitution is not possible without modifying existing instrumentation. However, in the aerospace, nuclear and semiconductor industries, where temperature measurement and control are especially critical, the benefits of a longer life and improved thermal emf stability cannot be ignored. In industry generally, there is also a considerable need for savings in the inspection, maintenance and calibration of thermocouple actuated pyrometric installations.

Extension and compensating wires for Nicrosil/Nisil thermocouples are available.

The following table lists the Nicrosil/Nisil emf-temperature characteristics against Pt 67 (NIST Monograph 175) based on ITS 90.

Nicrosil/Nisil E.M.F. Reference Table (mV) - Reference Junction 0 °C

°C	0	10	20	30	40	50	60	70	80	90	100
0	0.000	0.261	0.525	0.793	1.065	1.340	1.619	1.902	2.189	2.479	2.774
100	2.774	3.072	3.374	3.680	3.989	4.302	4.618	4.937	5.260	5.585	5.913
200	5.913	6.245	6.579	6.916	7.255	7.597	7.941	8.288	8.637	8.988	9.341
300	9.341	9.696	10.054	10.413	10.774	11.136	11.501	11.867	12.234	12.603	12.974
400	12.974	13.346	13.719	14.094	14.469	14.846	15.225	15.604	15.984	16.362	16.748
500	16.748	17.131	17.515	17.900	18.286	18.672	19.059	19.447	19.835	20.224	20.613
600	20.613	21.003	21.393	21.784	22.175	22.566	22.958	23.350	23.742	24.134	24.527
700	24.527	24.919	25.312	25.705	26.098	26.491	26.883	27.276	27.669	28.062	28.455
800	28.455	28.847	29.240	29.632	30.024	30.416	30.807	31.199	31.590	31.981	32.371
900	32.371	32.769	33.151	33.541	33.930	34.319	34.707	35.095	35.482	35.869	36.256
1000	36.256	36.641	37.027	37.411	37.796	38.179	38.562	38.944	39.326	39.706	40.087
1100	40.087	40.466	40.845	41.223	41.600	41.976	42.352	42.727	43.101	43.474	43.846
1200	43.846	44.218	44.588	44.958	45.326	45.694	46.060	46.426	46.789	47.152	47.513
1300	47.513										

Standard E.M.F. against Pt 67 - Nicrosil Leg (Positive)

Temp. °C	0	100	200	300	400	500	600	700	800	900	1000	1100	1200	1300
E.m.f.(mV)	0.000	1.784	3.943	6.348	8.919	11.603	14.370	17.202	20.094	23.045	26.046	29.083	32.144	35.221

Reference junction °C.