

## AA CuAl12Fe

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Copper-Aluminum GMAW composite welding wire for cladding applications.

**APPLICATIONS** Cladding components undergoing metal to metal wear with high friction and or heavy surface loads on top of cast iron, steels and or bronzes.

**PROPERTIES**

- Special alloyed copper composite wire suitable for the Mig process
- The weld metal is a Cu-Al bronze with extreme high aluminium content.
- Sound, pore free deposits with excellent sliding properties and low friction.

**CLASSIFICATION**

AWS	A 5.01: Class T3
EN ISO	14700: TCu1
DIN	8555: MSG31-GF-300-C

**SUITABLE FOR** Deep drawing dies for stainless steel, aluminium, magnesium and titanium parts. Sleeves, spindles, cable winches guides, gliding surfaces, pulling equipment. (usually preheating 300°C prior to welding is recommended to reduce cracks)

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

Mn	Cu	Al	Fe	Ni
0.5	Bal.	12.5	3.6	0.35

**MECHANICAL PROPERTIES**

Deposit type	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Melting range °C	Hardness HB
				+20°C	-40°C		
3 layers							320

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A) DC+	spool type	kg / spool
1,2	22-25 pulsed / 27-31	150-320	KD-300	15
1,6	22-25 pulsed / 27-31	200-350	KD-300	15

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** I1, I3