

AA CuAl14Fe

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: MSG 31-GF-400-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 %

C	Cu	Al	Fe
0.20	Bal.	13.50	4.0

MECHANICAL PROPERTIES

Deposit type	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V		Melting range °C	Hardness HB
				+20°C	-40°C		
3 layers							420

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