

CuAl5Ni2

CATEGORY GMAW-GTAW Solid wires

TYPE Copper aluminium nickel alloy for Mig welding and brazing

APPLICATIONS Low alloyed aluminum bronze, particularly suitable for joint welds on ferritic and austenitic steels. Good flowing properties with good cover groove, also suitable for joint welds on steels and copper. For multiplayer welding on steels, pulsed arc welding is recommended. Amazing results are obtained on stainless steel sheet metal due to less heat input, higher travel speed and less cleaning hours. Containers, valve control chambers, exhaust parts, thin sheet welding (steel and specially stainless steel) Ship propellers, shipbuilding, pump building, shafts, guide grooves etc.

PROPERTIES Sound, pore free deposits on ferrous and non-ferrous base materials with excellent wetting. Due to the excellent wetting and low melting point welding speeds can be achieved upto 2 mtr/min. The weld deposit offers a corrosion resistance similar to AISI 304.

CLASSIFICATION

AWS	A 5.7: no standard
EN ISO	24373: Cu6061 CuAl5Ni2Mn
DIN	1733: ~SG CuAl5Ni2

APPROVALS CE approved

WELDING POSITIONS:



CHEMICAL COMPOSITION

Mn	Ni	Al	Cu	Other
0.1-0.5	1.6-2.0	4.5-5.0	bal	<0.5

MECHANICAL PROPERTIES

Heat Treatment	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		
AW		353	45	161		1060-1085	84

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
0.8	25-26	80-140	D-300 / Drum	15 / 250	1080
1.0	26-27	130-200	D-300 / Drum	15 / 250	1080
1.2	27-28	185-245	D-300 / Drum	15 / 250	1080
1.6	28-30	250-400	D-300 / Drum	15 / 250	1080

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I, Ar-He (70-30)