

CuAl8Ni2

CATEGORY GMAW-GTAW Solid wires

TYPE Mig Aluminium / Nickel alloyed copper welding wire

APPLICATIONS Joint welds or building up of aluminum bronze. Cladding components undergoing metal to metal wear under high pressure. Especially suited for marine environments. The addition of nickel improves corrosion resistance in heat and rough seawater.

PROPERTIES

- Special alloyed copper wire for the Mig process
- The weld metal is a Cu-Al-Ni bronze
- Sound, pore free deposits on ferrous and non-ferrous base materials
- Excellent resistance to cavitations and stress corrosion cracking.

CLASSIFICATION

AWS	A 5.7: no standard
EN ISO	24373: S Cu 6327 (CuAl8Ni2Fe2Mn2)
DIN: W.Nr.	2.0922
DIN	1733: SG-CuAl8Ni2

SUITABLE FOR This filler metal with increased strength and corrosion properties is very well suited for Ship propellers, shipbuilding, pump building, shafts, guide grooves etc. W.Nrs: 2.0916, 2.0920, 2.0928, 2.0932, 2.0936, 2.0940, 2.0960, 2.0962, 2.0966, 2.0970, 2.0978, 2.0980.

WELDING POSITIONS:



WELD METAL ANALYSIS %

Fe	Mn	Ni	Al	Cu
2.0	2.0	2.0	8.0	bal

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		530				1030-1050	140

AW: as welded

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters			Packing	
	Voltage (V)	Current (A)	Spool type	kg / spool	kg / pallet
0,8	25-26	80-140	D-200 / KD-300	5 / 15	1000 / 1080
1,0	26-27	130-200	D-200 / KD-300	5 / 15	1000 / 1080
1,2	27-28	185-245	KD-300	15	1080
1,6	28-30	250-400	KD-300	15	1080

REDRYING TEMPERATURE Not required

TIG WELDING 1000 mm length rods are available ranging from 1,6 till 5,0 mm in 5 tubes