

## CuAl9Fe

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Copper-aluminium welding wire for Mig / Tig

**APPLICATIONS** Joint welds or building up of aluminum bronze. Cladding components undergoing metal to metal wear. Joining steel to copper alloys, cast iron and or bronze.

**PROPERTIES**

- Special alloyed copper wire for Mig and Tig welding
- The weld metal is a Cu-Al bronze
- Sound, pore free deposits.

**CLASSIFICATION**

AWS	A 5.7: ER CuAl-A2
EN ISO	24373: Cu6180 CuAl10Fe
DIN: W.Nr.	2.0937
DIN	1733: SG-CuAl9Fe

**SUITABLE FOR** Suitable for seawater resistant applications. Joining steel to copper alloys, cast iron and or bronze. Excellent for metal spraying. Ship propellers, shipbuilding, pump building, shafts, guide grooves etc, UNS : C 60600 - C 61600 - C 68700, DIN : Cu Al5 - Cu Al8 - CuZn20Al2, Werkstoff Nr : 2.0916 - 2.0920 - 2.0960

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

Mn	Ni	Fe	Al	Cu	rest
>1.0	-	1.0-1.3	9.0-9.5	bal	<0.5

**MECHANICAL PROPERTIES**

Heat Treatment	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 2.5/62.5
				+20°C	-40°C		
AW		500	35	95		1030-1040	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	KD-300	15	1080	
1.0	26-27	130-200	KD-300	15	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** Tig rods in 1000 mm length are available from 1.6 til 3.2 mm in 5 kg tubes