

CuAl 8

CATEGORY GMAW-GTAW Solid wires

TYPE Copper aluminium alloy for Mig welding and brazing

APPLICATIONS Rebuilding brass ship propellers and cladding surfaces against wear and corrosion attack. Welding galvanized plates or stainless steel sheets and suitable for cladding cast iron and un- and low alloyed steels.

PROPERTIES

- High quality alloyed copper wire for the Mig process (Mig brazing as well)
- The weld metal is a Copper-Aluminum bronze
- Sound, pore free deposits on ferrous and non-ferrous base materials
- Excellent corrosion resistance

CLASSIFICATION

AWS	A 5.7: ER CuAl-A1
EN ISO	24373: Cu 6100-CuAl7
DIN: W.Nr.	2.0921
DIN	1733-1: SG CuAl8

SUITABLE FOR Brass, copper, steel, CuZn alloys, Ship propeller, AISI 304, sliding Surface, shafts, bearings etc.

WELDING POSITIONS:



WELD METAL ANALYSIS %

Mn	Ni	Cu	Al	Other
0.10-0.30	0.10-0.50	bal	7.50-8.0	<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 2.5/62.5
				+20°C	-40°C		
AW		430	40	100		1030-1040	100

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spools 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 1000 mm length Tig rods are available ranging from 1,6 till 5,0 mm in 5 kg tubes