

## E CuAl8

**CATEGORY** SMAW Stick Electrodes

**TYPE** Basic coated aluminium bronze electrode developed for welding on DC+. Good tensile strength alloy with good corrosion resistance.

**APPLICATIONS** Ceweld CuAl-8 is designed for joining steel with copper or its alloys and cladding steel or aluminium bronze.

**PROPERTIES** The weld deposit offers good wear and corrosion resistance even in seawater. Welding instructions: - Preheating for sections >6 mm from 150 till 300°C is recommended. - Use the normal standard welding techniques.

**CLASSIFICATION**

AWS	A 5.6: E Cu Al-A1
EN ISO	1071: E CuAl 2 B2
DIN	1736: E 31-UM-150

**SUITABLE FOR** Aluminium bronze, cladding steel, shafts, gliding surfaces, joining steel to, aluminium bronze or copper, etc.

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

Cu	Al	Fe	Mn
89	8	0.70	1

**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			Hardness HB
				-20°C	-40°C	-60°C	
AW	180	420	> 20				180

AW: as welded

**WELDING PARAMETERS PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
2.5	300	80-100			15.8
3.2	350	90-120			31.9
4.0	350	120-140			47.7

**REDRYING TEMPERATURE** 150C / 2hr