CEWELD®

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	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V +20°C	Impact Energy (J) ISO-V -40°C	Melting range °C	Hardness HB 2.5/62.5
AW		500	35	95		1030-1040	140

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	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 lenght are available from 1.6 til 3.2 mm in 5 kg tubes