


CATEGORY	GTAW Solid wires				
TYPE	Copper aluminium alloy for Tig 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 Tig process (Tig 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: ERCuAl-A1			
	EN ISO	24373: Cu 6100 / CuAl7			
	F-nr	36			
	W.Nr.	2.0921			
SUITABLE FOR	Brass, copper, steel, CuZn alloys, Ship propeller, AISI 304, sliding Surface, shafts, bearings etc.				
APPROVALS	No Approvals Found				
WELDING POSITIONS:					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)					
Si	Mn	Zn	Pb	Al	
0.08	0.3	0.1	0.01	7	
ALL WELD MECHANICAL PROPERTIES					
Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT	Hardness Brinell Hardness Avg. 100
As Welded /		430	40	100	
WELDING PARAMETERS / PACKING					
REDRYING TEMPERATURE	Not required				
GAS ACCORDING EN 14175	I1, I3				