CEWELD® CuAl8Ni2 Tig

CATEGORY	GTAW Solid wires
TYPE	TIG Aluminium / Nickel alloyed copper welding wire
APPLICATIONS	Joint welds or building up of aluminum bronze. Cladding components undergoing metal to metal wear under high pressure. Especially suited for marine environments. The addition of nickel improves corrosion resistance in heat and rough seawater.
PROPERTIES	Special alloyed copper wire for the TIG process. The weld metal is a Cu-Al-Ni bronze. Sound, pore free deposits on ferrous and non-ferrous base materials. Excellent resistance to cavitations and stress corrosion cracking.
CLASSIFICATION	EN ISO 24373: Cu 6327 / CuAl8Ni2Fe2Mn2
SUITABLE FOR	This filler metal with increased strength and corrosion properties is verry well suited for Ship propellers, shipbuilding, pump building, shafts, guide grooves etc. W.Nr: 2.0916,2.0920, 2.0928, 2.0932, 2.0936, 2.0940, 2.0960, 2.0962, 2.0966, 2.0970, 2.0978, 2.0980.
APPROVALS	No Approvals Found
WELDING POSITIONS:	

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Si	Mn	Fe	Zn	Pb	Al	Ni+Co
0.1	2	2	0.1	0.01	8.5	2.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)		Hardness Brinell Hardness
As Welded /		530			Avg. 140

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	PACKING (KG)	PACKING (KG)
D (MM)	CURRENT (A) (DC-)	SINGLE	MASTER
2.0 X 1000	120-180	5	25
2.4 X 1000	160-230	5	25
3.0 X 1000	200-330	5	25

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1, I3