

CATEGORY GTAW Solid wires

TYPE Solid high strength CuMnAlNi alloyed welding wire rode.

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 manganese and nickel improves hardness and strength. Excellently suitable for joining and cladding of copper alloys, unalloyed and low-alloy steels and grey cast iron.

PROPERTIES Highest grade of the Al-Bronze-types. Seawater-resistant copper-aluminum alloy without Zn with high toughness and improved hardness. "Very good weldability compare to the more common Al. bronzes."


CLASSIFICATION

AWS	A 5.7: ERCuMnNiAl
EN ISO	24373: Cu 6338 / CuMn13Al8Fe3Ni2
F-nr	37
W.Nr.	2.1367

SUITABLE FOR Ship propellers, copper, brass, pumps, seawater, desalting equipment, marine, pulling tools, shafts, guide grooves, sliding surfaces, cast iron, putly, UNS : C62300 - C63000, DIN : CuAl10Fe3Mn2 - CuAl10Ni5Fe4 - G-CuAl10Fe, Mat n° : 2.0936 - 2.0966 - 2.0940, CuNiAl, superstone etc..

APPROVALS No Approvals Found

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Si	Mn	Fe	Al	Ni+Co
0.1	13	3	8	2.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Hardness Brinell Hardness
As Welded /		600	15	Avg. 220

WELDING PARAMETERS / PACKING

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 I1, I3