BRONWELD CuAl

Electrodes MMA [SMAW]

Aluminium alloys

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 24373-A : Cu 6100 (CuAl7) DIN 1733 : E CuAl-8 AWS A-5.6 : E CuAl-A2 W.Nr. : 2.0926		Hardfacing and repairing

- Electrode for welding and surfacing of alu-bronzes, for joining alu-bronzes with steel, for joining steel with copper and its alloys.
- Weld metal has high strength, good abrasion and corrosion resistance, especially in salt water.
- Weld metal is resistant to most acids over a wide temperature range.

Base material

UNS	DIN	W.Nr.	PN
C60600	CuAl5	2.0916	
C61000	CuAl8	2.0920	BA8
	G-CuAl9	2.0928	
C68700	CuZn20Al2	2.0460	
C61400	CuAl8Fe3	2.0932	BA83
Copper-beryllium alloys Cu+0.5-2%Be			
Cu-Zn brasses			
Aluminum brass Cu22%, Zn2%Al			
Manganese bronzes Cu+20-45%Zn+1-3%Mn			
Silicon bronzes Cu+1-3.5%Si			

Typical chemical composition %

Cu	Al
89,0	8,0

Typical mechanical properties

Tensile strength Rm [N/mm2]	480
Hardness	After welding 80-100HB / After hardening app. 140HB /
Coating type	basic
Welding current	
Welding positions	
Redrying	300°C / 2 h

	interstitch temperature should not exceed 200 [°C]. When welding brass, preheat 100-300[°C]. In alloys with a higher content of zinc, heat less. The shortest possible arc is recommended. Spread the material sideways as quickly as possible. Care should be taken when welding chromium-containing materials as brittleness and cracking may occur. The microstructure of the α + β duplex.
Welding parameters and packing	Recommendations: Preheating is not required for aluminum bronzes. The

ø	Length [mm]	Welding current [A]	Weight of carton [kg]	Pcs/1 kg
2,5	300 /	40-70	20,0	63
3,2	350 /	80-120	20,0	31
4,0	350 /	120-150	20,0	20
5,0	450 /	130-190	30,0	11

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl