

BRONWELD CuMn

Electrodes MMA [SMAW]

Stopy miedzi

CLASSIFICATION: DIN 1733 : E CuMn13Al7 AWS A-5.6 : E CuMnNiAl W.Nr. : 2.1367	APPROVALS:	APPLICATION: Hardfacing and repairing
--	-------------------	---

- Electrode for joining and surfacing aluminum and bronze, for welding steel and cast iron with copper and bronze.
- A weld metal with high strength parameters.
- Increased hardness.
- High ductility.
- Resistant to corrosion, cavitation, erosion, friction and seawater.
- The low coefficient of friction makes it suitable for sliding surfaces.



Base material

UNS	DIN	W.Nr.
C62300 - C63000	CuAl10Fe3Mn2 - CuAl10Ni5Fe4	2.0936 - 2.0966
C95200	G-CuAl10Fe2	2.0940
Low alloyed steels	CuNiAl	
Cast iron		
Non-alloyed steels		
Micro-alloyed steels		
Copper alloys		

Typical chemical composition %

Mn	Ni	Cu	Fe	Al
13,0	2,5	75,0	2,5	7,8

Typical mechanical properties

Tensile strength Rm [N/mm²]	640-735
Hardness	After welding 180-210 HB / After hardening 200-240 HB /
Welding current	
Welding positions	
Redrying	300°C / 2 h
Remarks	Thoroughly clean the welding area. Preheat larger items to approx. 150-250°C. Guide the electrode vertically, without spreading to the sides. It is absolutely necessary to dry the electrode.

Welding parameters and packing

∅	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	350 /	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