



CuAl8Ni2

ISO 24373: S-Cu 6327 (CuAl8Ni2Fe2Mn2)

DESCRIPTION

Joint welds between steel and CuAl alloys and rebuilding of aluminium bronzes. Also used for cladding applications involving metal to metal wear or corrosion by sea water. High wear and abrasion resistance. Very good corrosion resistance against seawater. High pressure resistance, especially with solenoid valves.

WELDING POSITIONS



CURRENT

DC+, Mig
DC(-), Tig

GAS

Ar, I1

BASE MATERIALS

Copper, brass

MECHANICAL PROPERTIES

<i>Tensile strenght (N/mm²)</i>	<i>Density kg/dm³</i>	<i>Elongation (%)</i>	<i>Hardness(HB)</i>	<i>Melting range(°C)</i>
530	7,5	30	140	1030-1050

WELD METAL COMPOSITION(%)

Cu	Al	Ni	Fe	Mn
Rest	8,0	2,0	2,0	2,0

PACKAGING

Mig (mm)	1,0	1,2	1,6	
Spool size (kg)	15	15	15	
Current (A)	80-140	130-200	185-245	250-400
Volt (V)	25-26	26-27	27-28	28-30
Tig (mm)	1,6	2,0	2,4	3,2
Box (kg)	5	5	5	5