



CuAl8Ni6

AWS A 5.7: ER CuNiAl ISO 24373: S-Cu 6328 (CuAl9Ni5)

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. Other applications include propellers, valves, gliding surfaces, bearings, sealings etc.

WELDING POSITIONS



CURRENT

DC+, Mig
DC(-), Tig

GAS

Ar, I1

BASE MATERIALS

Copper, brass, steel, aluminium bronze

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>
690	7,5	19	>200	1015-1045

WELD METAL COMPOSITION(%)

Cu	Al	Ni	Fe	Mn
Rest	8,5-9,5	4,0-5,5	3,0-5,0	0,6-3,5

PACKAGING

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