MIG CUA8

Old reference: MIG CuAl8

Classification

ISO 24373 : S Cu 6100 (CuAl7) Material N° : 2.0921
AWS A5.7 : ERCuAl-A1

Description & Applications

GMAW wire electrode recommended for assemblies made of copper-aluminium like pipelines and heat exchangers.
In general, the product has an excellent resistance to friction and to marine corrosion. Also used in assemblies of galvanised sheets, special brass (CuZn20Al). Frequently used for hardfacing pumps.

Base materials:

UNS	Alloy	DIN	Material N°
C60600		CuAl5	2.0916
C61000		CuAl8	2.0920
C68700	Yorcalbro	CuZn20Al2	2.0460

Typical Chemical Composition (%)

Si	Fe	Mn	Ni	Pb	Al	Zn	Cu
0.03	0.05	0.1	0.2	<0.02	8.1	<0.1	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
190	430	42

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +				Ar Ar + He

Preheating at 200 to 300°C is advised to massive parts, thickness > 3mm

Ind.10

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