




CEWELD CuAl9Fe

TYPE	Copper-aluminium welding wire for Mig																
APPLICATIONS	Joint welds or building up of aluminum bronze. Cladding components undergoing metal to metal wear. Joining steel to copper alloys, cast iron and or bronze.																
PROPERTIES	Special alloyed copper wire for Mig welding. The weld metal is a Cu-Al bronze. Sound, pore free deposits.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.7: ERCuAl-A2</td> </tr> <tr> <td>EN ISO</td> <td>24373: Cu 6180 / CuAl10Fe</td> </tr> <tr> <td>W.Nr.</td> <td>2.0937</td> </tr> <tr> <td>F-nr</td> <td>36</td> </tr> </table>	AWS	A 5.7: ERCuAl-A2	EN ISO	24373: Cu 6180 / CuAl10Fe	W.Nr.	2.0937	F-nr	36								
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W.Nr.	2.0937																
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SUITABLE FOR	Suitable for seawater resistant applications. Joining steel to copper alloys, cast iron and or bronze. Excellent for metal spraying. Ship propellers, shipbuilding, pump building, shafts, guide grooves etc, UNS : C 60600 - C 61600 - C 68700, DIN : Cu Al5 - Cu Al8 - CuZn20Al2, Werkstoff Nr : 2.0916 - 2.0920 - 2.0960																
APPROVALS																	
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 16.6%;">Si</td> <td style="width: 16.6%;">Fe</td> <td style="width: 16.6%;">Cu</td> <td style="width: 16.6%;">Zn</td> <td style="width: 16.6%;">Pb</td> <td style="width: 16.6%;">Al</td> </tr> <tr> <td>0.05</td> <td>1</td> <td>Rem.</td> <td>0.01</td> <td>0.01</td> <td>10</td> </tr> </table>	Si	Fe	Cu	Zn	Pb	Al	0.05	1	Rem.	0.01	0.01	10				
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MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> <tr> <td>As Welded</td> <td></td> <td>500</td> <td>35</td> <td colspan="2">95</td> <td>140 HB</td> </tr> </table>	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT		As Welded		500	35	95		140 HB
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		RT															
As Welded		500	35	95		140 HB											
REDRYING	Not required																
GAS ACC. EN ISO 14175	11, 13																



CEWELD CuAl9Fe

CUAL9FE 1,0MM

Packaging	KG/unit	EanCode
D-300	15	8720663408846

CUAL9FE 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663408853

CUAL9FE 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663408860