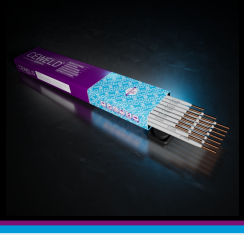

CEWELD E CuAl8

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic coated aluminium bronze electrode developed for welding on DC+. Good tensile strength alloy with good corrosion resistance.

APPLICATIONS

CEWELD E CuAl8 is designed for joining steel with copper or its alloys and cladding steel or aluminium bronze.

PROPRIÉTÉS

The weld deposit offers good wear and corrosion resistance even in seawater. Welding instructions:
- Preheating for sections >6 mm from 150 till 300 °C is recommended. Use the normal standard welding techniques.

CLASSIFICATION

AWS	A 5.6: ECuAl-A2
EN ISO	17777: E Cu 6100A
W.Nr.	2.0926
F-nr	31

CONVIENT POUR

Aluminium bronze, Cladding steel, Shafts, Gliding surfaces, Joining steel to, Aluminium Bronze or Copper, etc.
Mat.n: 2.0916, 2.0920, 2.0928, 2.0460, 2.0932
CuAl5, CuAl8, G-CuAl9, CuZn20Al2, CuAl8Fe3,
UNS: C60600, C61000, C68700, C61400,
Copper-beryllium alloys Cu+0.5-2%Be, Cu-Zn brasses, Aluminum brass Cu22%, Zn2%Al, Manganese bronzes Cu+20-45%Zn+1-3%Mn, Silicon bronzes Cu+1-3.5%Si

AGRÉMENTS

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

Si	Mn	Fe	Pb	Al	Cu
0.7	0.5	0.8	0.01	7.5	Rem.

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	200	450	24	150 HB

ETUVAGE

Not required

GAS ACC. EN ISO 14175