MIG CUA8

Old reference: MIG CuAl8

Classification

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

Description & Applications

Solid wire for GMAW of Copper-Aluminium alloys with Aluminium content up to 10%. Also used for heterogenous assemblies between copper alloys and steels, galvanised sheets, special brass (CuZn20Al) and for hardfacing of wearing surfaces.

Main applications: Shipyard building, chemical industry (desalination of sea water).

Base materials:

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

Typical Chemical Composition (%)

	Al	Fe	Mn	Ni+Co	Pb	Si	Sn	Zn	O/T	Cu
Min	6.0									
Max	8.5		0.50		0.02	0.10		0.20	0.4	Rem.
Type	8.0	0.05	0.01	0.1	0.005	0.02	0.01	0.02	<0.4	Rem.

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
Min	-	-	-
Max			
Type	180	400	40

Welding Current & Instructions

	Ø (mm)	Welding parameters		Shielding gas
		Current (A)	Voltage (V)	
GMAW = +	0.8 1.0 1.2	120 - 180 180 - 220 220 - 250	20 - 22 22 - 24 24 - 26	ISO 14175: I1 (100% Ar) I2 (100% He) I3 (Ar+ 5-30%He) 12-18 l/min

Preheating of massive parts between 200°C (>6mm) up to 500°C (>15mm).

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Fumes: Consult information on MSDS, available upon request.