



# MIG CUA8NI

Old reference: MIG CuAl9Mn

## Classification

ISO 24373 : S Cu 6327 (CuAl8Ni2Fe2Mn2)

## Description & Applications

Solid wire for GMAW of Copper-Aluminium alloys with similar chemical composition.

**Main applications:** Welding and reparation of pumps and piping systems for sea water. Often used in anti-wear surfacing. The product corresponds to Indret N°108 specifications for shipbuilding.

## Typical Chemical Composition ( % )

	Al	Fe	Mn	Ni+Co	Pb	Si	Zn	O/T	Cu
Min	7.0	0.5	0.5	0.5					
Max	9.5	2.5	2.5	3.0	0.02	0.2	0.2	0.4	Rem.
Type	8.5	1.4	1.8	2.3	0.005	0.03	0.01	<0.4	Rem.

## All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
Min	-	-	-
Max			
Type	330	650	27

## Welding Current & Instructions

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

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

FT En-MU08-200302

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**Fumes:** Consult information on MSDS, available upon request.

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