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

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
Min	-	-	-
Max			
Type	330	650	27

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).