



MIG CUA9

Old reference: MIG CuAl9

Classification

ISO 24373 : S Cu 6180 (CuAl10Fe)

AWS A5.7 : ERCuAl-A2

Description & Applications

Solid wire for GMAW of cupro-aluminium alloys with similar chemical composition. Deposits are harder than those of TIG CUA8, and are often used for hardfacing of ferritic/perlitic steels. High resistance against wear and abrasion.

Main applications: Assemblies for welding and hardfacing of aluminium-bronze, of aluminium covered steels, of cast iron in machining tools industry and in naval construction.

Typical Chemical Composition (%)

	Al	Fe	Pb	Si	Zn	O/T	Cu
Min	8.5						
Max	11.0	1.5	0.02	0.10	0.02	0.50	Rem.
Type	9.5	1.2	0.005	0.03	0.005	<0.50	Rem.

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	-	-	-
Max			
Type	300	550	20

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-MU09-200302

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Fumes: Consult information on MSDS, available upon request.

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