



MIG CUMN13

Old reference: MIG Cu118

Classification

AWS A5.7 : ERCuMnNiAl

ISO 24373 : S Cu 6338 (CuMn13Al8Fe3Ni2)

Description & Applications

Solid wire for GMAW of Copper-Aluminium, for surfacing on steels and cast iron as well as for cavitation resistant overlays. It has high resistance to wear and marine / sea water corrosion.

Main applications: Ship building, chemical industry, surfacing of wearing surfaces, assemblies exposed to sea water, exchanger for petrochemical and electrical plant.

Base materials:

UNS	DIN	Material N°
C62300	CuAl10Fe3Mn2	2.0936
C63000	CuAl10Ni5Fe4	2.0966
	G-CuAl10Fe	2.0940
	CuAl9Mn2	2.0960
	G-CuAl8Mn	2.0962

Typical Chemical Composition (%)

	Al	Fe	Mn	Ni+Co	Pb	Si	Zn	O/T	Cu
Min	7.0	2.0	11.0	1.5					
Max	8.5	4.0	14.0	3.0	0.02	0.10	0.15	0.50	Rem.
Type	8.0	2.3	12.0	2.1	0.005	0.04	0.005	<0.50	Rem.

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	-	-	-
Max			
Type	400	650	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-MU11-200302

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Fumes: Consult information on MSDS, available upon request.

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