



TIG CUA8NI

Old reference: TIG CuAl9Mn

Classification

ISO 24373 : S Cu 6327 (CuAl8Ni2Fe2Mn2)

Description & Applications

Solid rod for GTAW 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

Welding mode	Shielding Gas
GTAW = -	ISO 14175: I1 (100% Ar) / I2 (100% He) / I3 (Ar+ 5-30%He) 5-10 L/min

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

FT En-TU08-170220

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group.

Fumes: Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr