



# CEWELD CuAl9Fe Tig

| TYPE  | Copper-Aluminium welding TIG rods   |                      |                         |                      |                           |          |           |       |      |      |        |       |      |
|---|---|----------------------|-------------------------|----------------------|---------------------------|----------|-----------|-------|------|------|--------|-------|------|
| APPLICATIONS                                      | Joint welds or building up of aluminum bronze. Cladding components undergoing metal to metal wear. Joining steel to copper alloys, cast iron and or bronze.   |                      |                         |                      |                           |          |           |       |      |      |        |       |      |
| PROPERTIES  | Special alloyed copper rods for Tig welding. The weld metal is a Cu-Al bronze. Sound, pore free deposits.   |                      |                         |                      |                           |          |           |       |      |      |        |       |      |
| CLASSIFICATION                                    | <table border="0"> <tr> <td>AWS</td> <td>A 5.7: ERCuAl-A2</td> </tr> <tr> <td>EN ISO</td> <td>24373: Cu 6180 / CuAl10Fe</td> </tr> <tr> <td>W.Nr.</td> <td>2.0937</td> </tr> <tr> <td>F-nr</td> <td>36</td> </tr> </table>  | AWS                  | A 5.7: ERCuAl-A2        | EN ISO               | 24373: Cu 6180 / CuAl10Fe | W.Nr.    | 2.0937    | F-nr  | 36   |      |        |       |      |
| AWS   | A 5.7: ERCuAl-A2  |                      |                         |                      |                           |          |           |       |      |      |        |       |      |
| EN ISO  | 24373: Cu 6180 / CuAl10Fe   |                      |                         |                      |                           |          |           |       |      |      |        |       |      |
| W.Nr.   | 2.0937  |                      |                         |                      |                           |          |           |       |      |      |        |       |      |
| F-nr  | 36  |                      |                         |                      |                           |          |           |       |      |      |        |       |      |
| SUITABLE FOR                                      | Suitable for seawater resistant applications. Joining steel to copper alloys, cast iron and or bronze. Excellent for metal spraying. Ship propellers, shipbuilding, pump building, shafts, guide grooves etc, UNS : C 60600 - C 61600 - C 68700, DIN : Cu Al5 - Cu Al8 - CuZn20Al2, Werkstoff Nr : 2.0916 - 2.0920 - 2.0960 |                      |                         |                      |                           |          |           |       |      |      |        |       |      |
| APPROVALS   |   |                      |                         |                      |                           |          |           |       |      |      |        |       |      |
| WELDING POSITIONS                                 |   |                      |                         |                      |                           |          |           |       |      |      |        |       |      |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1"> <thead> <tr> <th>Si</th> <th>Fe</th> <th>Cu</th> <th>Zn</th> <th>Pb</th> <th>Al</th> </tr> </thead> <tbody> <tr> <td>0.064</td> <td>0.94</td> <td>Rem.</td> <td>0.007</td> <td>0.015</td> <td>9.21</td> </tr> </tbody> </table>  | Si                   | Fe                      | Cu                   | Zn                        | Pb       | Al        | 0.064 | 0.94 | Rem. | 0.007  | 0.015 | 9.21 |
| Si  | Fe  | Cu                   | Zn                      | Pb                   | Al                        |          |           |       |      |      |        |       |      |
| 0.064   | 0.94  | Rem.                 | 0.007                   | 0.015                | 9.21                      |          |           |       |      |      |        |       |      |
| MECHANICAL PROPERTIES                             | <table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R<sub>p0,2</sub> (MPa)</th> <th>R<sub>m</sub> (MPa)</th> <th>A<sub>5</sub> (%)</th> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td></td> <td>500</td> <td>35</td> <td>140 HB</td> </tr> </tbody> </table>                                 | Heat Treatment       | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%)        | Hardness | As Welded |       | 500  | 35   | 140 HB |       |      |
| Heat Treatment                                    | R <sub>p0,2</sub> (MPa)   | R <sub>m</sub> (MPa) | A <sub>5</sub> (%)      | Hardness             |                           |          |           |       |      |      |        |       |      |
| As Welded   |   | 500                  | 35                      | 140 HB               |                           |          |           |       |      |      |        |       |      |
| REDRYING  | Not required  |                      |                         |                      |                           |          |           |       |      |      |        |       |      |
| GAS ACC. EN ISO 14175                             | I1  |                      |                         |                      |                           |          |           |       |      |      |        |       |      |



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|                          |           |         |               |
|--------------------------|-----------|---------|---------------|
| CUAL9FE TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode       |
|                          | Tube      | 5       | 8720663408914 |
| CUAL9FE TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                          | Tube      | 5       | 8720663408945 |
| CUAL9FE TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode       |
|                          | Tube      | 5       | 8720663408969 |
| CUAL9FE TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                          | Tube      | 5       | 8720663409003 |