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| Technical data sheet 011121MBA | Copper base – Solid wire WA TCU/MCU AI8 |  Welding Alloys |
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CLASSIFICATION

ASME IIC SFA 5.7 / AWS A 5.7: ERcAl-A1
 EN ISO 24373: S Cu 6100 (CuAl7)

DESCRIPTION

- GTAW rod / GMAW copper base solid wire
- Deposits a cupro-aluminium bronze with 8% aluminium
- Corrosion and friction wear resistant

APPLICATIONS

- Welding cupro-aluminium alloys, copper and copper alloys.
- Joining and surfacing parts subjected to metal to metal wear under high compressive stresses or in the presence of corrosive agents such as sea water or acids.

TYPICAL WIRE ANALYSIS [weight %]

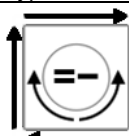
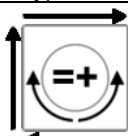
| Cu | Al |
|------|-----|
| Bal. | 7.8 |

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

| Rm [MPa] | Rp0.2% [MPa] | A ₅ [%] | CVN [J] |
|----------|--------------|--------------------|------------|
| 430 | 200 | 40 | +20°C: 100 |

All-weld metal hardness: 100 HB
 Thermal conductivity: 65 W/m*K

SHIELDING GAS – OPERATING CONDITIONS – WELDING POSITIONS

| GTAW | | GMAW | |
|---|---|---|---|
| Shielding gas according to EN ISO 14175 | Welding positions Current type | Shielding gas according to EN ISO 14175 | Welding positions Current type |
| I1 (100 % argon) |  | I1 (100 % argon) I3 (e.g : Ar + 30 % He) |  |

GMAW: Preheating thick sections is mandatory. Pulsed current mode is recommended for surfacing on iron base materials.

Pulsed arc welding is recommended for the first surfacing layer on iron base materials.

GTAW: fluxing agents are recommended to prevent oxide formation.

PACKAGING

| Spools | Ø mm | 0.8 | 1.0 | 1.2 | 1.6 | |
|--------|------------|-----|-----|-----|-----|-----|
| Rods | Ø x1000 mm | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 |

Other dimensions on request

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.