


<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Copper base – Solid wire</b>  <b>WA TCU/MCU Al8Ni2</b>	 <b>Welding Alloys</b>
---	---	---

### CLASSIFICATION

EN ISO 24373: S Cu 6327 (CuAl8Ni2Fe2Mn2)

### DESCRIPTION

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

### APPLICATIONS

- Welding cupro-aluminium alloys, copper and copper alloys when increase wear resistance is required
- Surfacing parts subjected to metal to metal wear

### TYPICAL WIRE ANALYSIS (weight %)

Cu	Al	Ni	Fe	Mn
Bal.	8.1	2.1	1.7	1.6


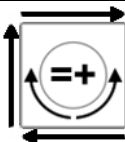
### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	As [%]	CVN [J]
530	270	25	+20°C: 70

All-weld metal hardness: 160 HB

Thermal conductivity: 50 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 only necessary on large workpieces. Pulsed arc welding is recommended for the first surfacing layer on iron base materials.

GTAW: preheating the base material is usually not necessary. 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.