


Technical data sheet <small>011121MBA</small>	Copper base – Solid wire WA TCU/MCU Mn13Al7	
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CLASSIFICATION

ASME IIC SFA 5.7 / AWS A 5.7: ERCuMnNiAl
EN ISO 24373: S Cu 6338 (CuMn13Al8Fe3Ni2)

DESCRIPTION

- GTAW rod / GMAW copper base solid wire
- High manganese cupro-aluminium bronze
- Especially suited for marine environments and sea water
- Good resistance to corrosion, cavitation, erosion and metal-to-metal wear

APPLICATIONS

- Welding Cu-Al, Cu-Al-Mn and Cu-Al-Ni alloys.
- Surfacing of ferrous and non-ferrous base materials

Examples: bearing surfaces of axles, shafts, slides and guides, gear teeth etc.

TYPICAL WIRE ANALYSIS [weight%]

Cu	Al	Mn	Fe	Ni
Bal.	7.7	12.3	2.2	2.1

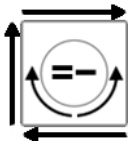

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2[MPa]	As [%]
650	400	20

All-weld metal hardness: 220 HB

Thermal conductivity: 30 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)	

Base materials can be preheated up to 120°C. Keep interpass temperature at maximum 150°C in order to avoid embrittlement of the deposit.

Pulsed current is recommended for the first layer when surfacing on iron base materials.

PACKAGING

Spools	Ø mm	1.0	1.2	1.6	
Rods	Ø x1000 mm	1.6	2.0	2.4	3.2

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.