

## Cu-base solid wire

### Classification

AWS A5.7-84R	: ERCuAl-A1
EN 14640	: S Cu 6100 (CuAl8)

### General description

Solid wire for welding copper-aluminium alloys, as aluminiumbronze  
High resistance to corrosion and wear

### Shielding gases (acc. EN 439)

GMAW	I1	Inert gas Ar (100%)
	I3	Inert gas Ar+ >0-95% He

### Chemical composition (w%). typical. wire

Cu	Al	Mn
bal.	8	0.3

### Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Hardness HB
Typical values	GMAW	I1	AW	185	430	30	95

### Materials to be welded

Material type	Code	Type	W.Nr.
Copper-aluminium wrought alloys	DIN 17665	CuAl5As	2.0918
		CuAl8	2.0920
Copper-aluminium cast alloys	DIN 1714	G-CuAl8Mn	2.0962

### Packaging and available sizes

Process	Unit	Diameter (mm)	0.8	1.0	1.2	1.6	2.0
GTAW	2 kg tube						X
GMAW	12 kg spool B300		X	X	X	X	

Other sizes and packaging on request

LNT/LNM CuAl8: rev. EN 20