CEWELD AA CuAl12NiFe

certilas® THE FILLER METAL SPECIALIST

TYPE

Copper-Aluminum FCAW composite welding wire for cladding applications.

APPLICATIONS

Cladding components undergoing metal to metal wear with high friction and or heavy surface loads on top of cast iron, steels and or bronzes. Ship propellers, Deep drawing dies for stainless steel, aluminium, magnesium and titanium parts. Sleeves, spindles, cable winches guides, gliding surfaces, pulling equipment. (Usualy preheating 300°C prior to welding is recomended to reduce cracks).

PROPERTIES

Special alloyed copper composite wire suitable for the Mig process.
The weld metal is a Cu-Al-Ni bronze with extreme high aluminium content.
Sound, pore free deposits with excelent sliding properties and low friction.

CLASSIFICATION

EN ISO 14700: T Cu1

SUITABLE FOR

Cu – Mn –Ni – Al bronze

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

Mn	Ni	Fe	Cu	Al
0.9	4.5	2.2	Rem.	12

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				320 HB

REDRYING

Not required

GAS ACC. EN ISO 14175

I1, I3

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AA CUAL12NIFE 1,2MM

Packaging	KG/unit	EanCode
D-300	13	8720663408938

AA CUAL12NIFE 1,6MM

Packaging	KG/unit	EanCode
D-300	13	8720663408952