

## AX-CuAl8Ni2

Material-No.: 2.0922

### Standards

EN ISO 24373:	S Cu 6327 (CuAl8Ni2Fe2Mn2)
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### Properties

Welding rod / wire of multi-component aluminium bronze for TIG or GMAW welding of copper-aluminium alloys. Corrosion and seawater resistant.

### Important base materials / Important applications

Copper-Aluminium-alloys with increased wear resistant, for example Al-bronze with 7-9% Al. The alloy is also used for deposit welding on unalloyed and low alloyed steels and cast steel and is also used as metal spray wire.

### Typical composition of welding rod / solid wire in %

Cu	Al	Ni	Fe	Mn
Base	8,1	2,1	1,7	1,6

### Mechanical properties of all-weld metal (typical values)

Yield strength $R_{p0,2}$	[MPa]	270
Tensile strength $R_m$	[MPa]	530
Elongation A ( $L_0 = 5d_0$ )	[%]	25
Impact work KV	[J]	70 bei +20°C
Hardness	[HB]	160
Thermal conductivity	[W/(m*K)]	50

Shielding gas: 100% Argon, PWHT: untreated

### Operating data

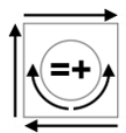
#### TIG:

Shielding gas: I1 (100%Argon)  
acc. to ISO 14175



#### GMAW:

I1 (100%Argon)  
I3 (e.g. Ar+30%He)



TIG: Preheating of the base material is not usually necessary. To remove oxides, welding under AC or the use of fluxing agents is recommended.

GMAW: Preheating only requested for large workpieces. Pulse arc welding is recommended for the first layer of deposition welding on iron base materials.

### Approvals

(Please ask for current scope)

### Packaging and available sizes

Spools	Ø mm	0,8	1,0	1,2	1,6		
Rods	Ø mm x 1000mm	2,0	2,4	3,2	4,0		

Other dimensions on request.