

AX-CuAl8Ni2 2.0922

Standard

EN ISO 24373
Material number

S-Cu 6327 (CuAl8Ni2)
2.0922

Area of application

Filler rod/filler wire of multi-alloy aluminium bronze for TIG or MIG welding of copper-aluminium alloys. Corrosion and saltwater-proof.

Special hints

TIG preheating of the base material is not required as a rule. MIG preheating only necessary for large workpieces. For the 1st layer of overlays on ferrous materials pulsed arc welding is recommended. When TIG welding use flux to avoid oxide formation.

Composition of the filler rod/filler wire (typical data in %)

Cu	Al	Ni	Fe	Mn			
Bal.	8.7	2.3	1.3	1.8			

Important base materials

Copper-aluminium-alloys with increased wear resistance, e.g. Al-bronze with 7-9% Al. Also for overlays on unalloyed and low alloyed steels and on cast iron. This alloy is also used as metal spray wire.

Material properties

Shielding gas	Argon	Mechanical properties of the weld metal according to EN ISO 15792-1	
Heat treatment	untreated		
Test temperature	20°C		
0.2%-yield strength $R_{p0.2}$	[MPa]		270
Tensile strength R_m	[MPa]		530
Elongation A ($L = 5d_0$ %)	[%]		25
Brinell hardness	[HB]		160
Impact strength A_v	[J]		70
Thermal conductivity	[W/(m*K)]	50	

Applicable shielding gases (EN ISO 14175)

TIG/MIG argon I1

Approvals

(Request current scope if required)

Product forms (other dimensions available on request)

Spool	Ø mm	0.8	1.0	1.2	1.6		
Rod	Ø mm x 1000 mm	2.0	2.4	3.2	4.0		