AX-CuAl8Ni6
2.0923

Standard

EN ISO 24373	S-Cu 6328 (CuAl9Ni5)	
Material number AWS A.5-7	2.0923 ERCuNiAl	

Area of application

Filler wire of multi-alloy aluminium bronze with Ni and Fe additive 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. Preheating only necessary for large workpieces. For the 1st layer of overlays on ferrous materials pulsed arc welding is recommended.

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

Cu	Al	Ni	Fe	Mn			
Bal.	9	4.5	3.5	1.3			

Important base materials

Copper-aluminium-nickel alloys, saltwater-proof overlays on unalloyed and low alloyed steels and on cast iron as well as for dissimilar joints on aluminium bronzes and steel.

Material properties

Shielding gas		Argon untreated	Mechanical properties of the weld metal
Heat treatment		20°C	according to EN ISO 15792-1
Test temperature		[MPa]	
0.2%-yield strength Rp	$_{0.2}$	[MPa] [%] [HB]	380
Tensile strength R_m		[W/(m*K)]	600
Elongation A (L = 5d %)	$_{0}$ $_{0}$		16
Brinell hardness			200
Thermal conductivity			30-40

Applicable shielding gases (EN ISO 14175)

MIG: argon I1

Approvals

(Request current scope if required)

Product forms (other dimensions available on request)

Spool	Ø mm	1.0	1.2				