



MIG / TIG CuA8

COPPER ALLOY

DESCRIPTION

Aluminum bronze solid wire **GMAW (MIG)** or **GTAW (TIG)** for rebuild aluminum bronze (up to 10% Al) but also for overlay steel parts.

CHARACTERISTICS

- Conform to standard AWS A5.7 and ASME SFA 5.7, class ERCuAl-A1
- Excellent for parts subject to corrosion and wear
- Excellent weldability
- Excellent machinability
- This alloy is not recommended for joining

TYPICAL APPLICATIONS

Propellers and impellers, couplings, bushings, valve seats, shafts, pumps, bearings, wear-resistant surfaces and anti-friction coating.

PROCEDURE

Remove any trace of oil, grease and dirt from the joint area. **Preheat copper and copper alloys between 200 and 600°C (450 - 1112°F) depending on the case.**

MECHANICAL PROPERTIES

Tensile strength:	469 MPa (68 000 psi)
Yield strength :	193 MPa (28 000 lb/po ²)
Elongation :	47 %
Hardness (as-welded) :	120-130 BH

WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas flow	Gas
GMAW MIG	0.9 mm (035")	22 - 26	150 - 200	40 to 50 CFH	100 % Argon or Argon + Helium
	1.2 mm (045")	25 - 29	200 - 260		
GTAW TIG	1.6 mm (1/16")	CC-		35 to 50 CFH	100 % Argon or Argon + Helium
	2.5 mm (3/32")				
	3.2 mm (1/8")				

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Specialized welding alloys and technology. For technical assistance or for ordering: