

FONTARGEN A 2115/5 Ni M

Copper-aluminium wire electrode for MIG-brazing



ISO 24373: S Cu 6061 (CuAl5Ni2Mn)

Composition, typical analysis (% w/w):

Al	Ni	Mn	Cu
5	2	0.2	Remainder

Characteristics / Applications:

Welded joints and deposit welding on aluminium bronze with 5 - 6 % Al, high-strength brass, copper and copper-alloys, ferritic and austenitic steel, steel, aluminium-coated steel, gray cast. Suitable for welding of galvanized steel (MIG-welding). Preheating is only necessary for big assemblies. Pulsed arc welding is recommended for the first layer of deposit welding on ferrous materials.

Mechanical properties of pure welding deposit

(Min. values at room temperature):

Melting range:	1060 - 1085 °C
Tensile strength:	360 - 450 N/mm ²
Elongation (l=5d):	45 %
Hardness (Brinell):	160 HB
Thermal conductivity:	61 W/m • K
Electrical conductivity:	8.0 - 8.8 Sm/mm ²
Specific gravity:	8.2 g/cm ³
Linear expansion:	17.5 • 10 ⁻⁶ /K

Welding process: MIG

Shielding gas (DIN EN 439): I 1 (Argon), M 12 (Ar + 2 % CO₂), M 12 (Ar + 1 % O₂)

Current mode: DC (+pole)

Availability: Diameter (mm): 0.8/1.0/1.2/1.6/2.4

Spool type: B300
S300
Drum

Welding position: according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
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