



SELECTARC Cu117

Cu-Al-Ni-Fe
Bronze Electrode

Classification

AWS A5.6 : ECuNiAl

UNS

: W60632

Characteristics

Basic coated electrode for joining and surfacing on Aluminium-Nickel bronze with upto 10% Al. Excellent weldability, stable arc, less spatters, easy slag removal.

Applications

Ship building, Sea water applications, Desalination plants, Chemical industry, Pumps parts which are attacked by sea water (Propellers, Bearings...)

Base materials

Cast and wrought Aluminium- Nickel Bronze

Typical Weld Metal Composition (%)

Al	Mn	Fe	Ni	Si	Pb	Cu
8.00	1.00	4.00	4.50	1.00	0.010	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R _m (MPa)	YS R _{p0.2} (MPa)	% Elg A ₅	Hardness (HB) AW
AW	650	380	12	190

Welding Current & Instructions

Electrode	ØxL (mm)	2.5 x 350	3.2 x 350	4.0 x 350
Current	(A)	80 - 100	90 - 120	120 - 140

Redrying of electrode at 250°C for 2hrs before use. Weld Joint must be clean, exempt from grease and cracks. Guide electrodes with a slight inclined angle (10-20°) in direction of travel. Weld with a short arc. To improve degassing of the deposit, adopt a slow welding speed. Heavy pieces (sections above 6 mm) have to be preheated to ~100°C.



1G/PA



2F/PB



2G/PC

= + ~ 70 V

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