



MIG CUMN13

Old reference: MIG Cu118

Classification

ISO 24373 : S Cu 6338 (CuMn13Al8Fe3Ni2) Material N° : 2.1368
 AWS A5.7 : ER CuMnNiAl

Description & Applications

Solid wire for GMAW used for assembly of copper-aluminium, for surfacing on steels and cast iron as well as for cavitation resistant overlayers. It has high resistance to wear and marine / sea water corrosion.

Base materials

UNS	DIN	Material N°
C62300	CuAl10Fe3Mn2	2.0936
C63000	CuAl10Ni5Fe4	2.0966
	G-CuAl10Fe	2.0940
	CuAl9Mn2	2.0960
	G-CuAl8Mn	2.0962

Typical Chemical Composition (%)

Al	Mn	Fe	Ni	Si	Zn	Cu
7.5	12.0	2.5	2.0	0.03	<0.15	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
400	650	20

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +				Ar Ar + He

Ind.10



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