



TIG CUA9

Old reference: TIG CuAl9

Classification

ISO 24373 : S Cu 6180 (CuAl10Fe)

AWS A5.7 : ERCuAl-A2

Description & Applications

Solid rod for TIG welding of cupro-aluminium alloys of similar composition. Deposits are harder than those of TIG CuAl8, and are often used for hardfacing of ferritic/perlitic steels. High resistance to wear and abrasion. Assemblies for welding and hardfacing of aluminium-bronze, of aluminium covered steels, of cast iron in machining tools industry and in naval construction. Welding of aluminium-bronze piping resistant to seawater corrosion, erosion and cavitation.

Typical Chemical Composition (%)

Fe	Zn	Al	Ni	Pb	Si	Cu
1.2	<0.02	9.8	0.007	<0.02	<0.1	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
	500	35

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 5-10 l/min Argon / He : 5-10 l/min

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