



# TIG CUMN13

Old reference: TIG Cu118

## Classification

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

## Description & Applications

Solid rod for TIG welding 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 ( % )

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

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
400	650	20

## Welding Current & Instructions

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

ind.10



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