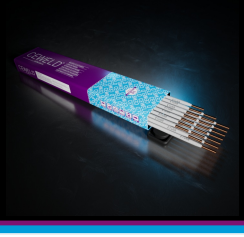

CEWELD E CuAl8

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic coated aluminium bronze electrode developed for welding on DC+. (E CuAl-A2, E Cu6100)

APPLICATIONS

CEWELD®E CuAl8 is an alkaline electrode for bonding aluminum bronzes with an Al content of max. 10 %, as well as for wear-resistant and corrosion-resistant coatings on steel, cast steel and cast iron, especially when exposed to erosion.
by erosion. **CEWELD®E CuAl8** is suitable for filling cavities in new aluminum castings, as a buffer layer between Cu and Ni alloys and as a bearing material under high compressive stress.

PROPERTIES

The weld metal of **CEWELD®E CuAl8** offers good wear and corrosion resistance. The weld metal has good mechanical properties, is acid-resistant and resistant to seawater and erosion.
Welding instructions: - Preheating for sections >6 mm from 150 to 300 °C is recommended. For thick sheets, a V-seam with a 90° opening angle should be made. Preferably weld in a horizontal position (PA) electrode perpendicular to the workpiece with a short arc, low current and high speed.

CLASSIFICATION

AWS	A 5.6: ECuAl-A2
EN ISO	17777: E Cu 6100A
W.Nr.	2.0926
F-nr	31

SUITABLE FOR

Aluminium bronze, Cladding steel, Shafts, Gliding surfaces, Joining steel to, Aluminium Bronze or Copper, etc.
Mat.n: 2.0916, 2.0920, 2.0928, 2.0460, 2.0932
CuAl5, CuAl8, G-CuAl9, CuZn20Al2, CuAl8Fe3,
UNS: C60600, C61000, C68700, C61400,
Copper-beryllium alloys Cu+0.5-2%Be, Cu-Zn brasses, Aluminum brass Cu22%, Zn2%Al, Manganese bronzes Cu+20-45%Zn+1-3%Mn, Silicon bronzes Cu+1-3.5%Si

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

Si	Mn	Fe	Pb	Al	Cu
0.7	0.5	0.8	0.01	7.5	Rem.

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	200	450	24	150 HB

REDRYING

140°C / 1 hr

GAS ACC. EN ISO 14175