

ML CuAl8

Rod/Wire electrode for Copper

Typical composition in %	Al 6,00-8,50 Si < 0,20 Mn < 0,50 Zn < 0,20 Pb < 0,02 Others total < 0,40
Classification	ISO 24373 S Cu 6100 (CuAl7) DIN 1733 SG-CuAl8 Material No. 2.0921 BS 2901 part 3 C 28 AWS A 5.7 ER Cu Al-A1
Base materials	CuAl5; CuAl8; CuAl9; CuZn20Al
Remarks	Filler metal for joining and surfacing of Al-bronze, brass, steel- and cast-iron, as well as for MIG-brazing of carbonsteel with and without coating. Suitable for joining of steel to copper. The weld metal is resistant to corrosion, wear and brackish water.
Physical properties (Approx. values)	Electrical conductivity [$S \cdot m/mm^2$] 8 Density [kg/dm^3] 7,7 Solidus-Temperature [$^{\circ}C$] 1030 Liquidus-Temperature [$^{\circ}C$] 1040 Tensile strength R_m [MPa] 390 - 450 Elongation A_5 ($L_0=5d_0$) [%] 45 Hardness [HB] 140
Welding position	PA, PB, PC, PE, PF
Shielding gas	I1, I2, I3 (Argon, Helium or Argon/Helium-mixtures)
Polarity	MIG =+, TIG ~
Dimensions Ø	MIG-wires [mm] 0,8; 1,0; 1,2; 1,6; 2,0; 2,4; 3,2 TIG-rods [mm] 1,6; 2,0; 2,4; 3,2; 4,0
Wire packagings	Spools Packaging units S 200 / 5 kg n/a S 300 / 15 kg 25 spools = 375 kg (pallet) B 300 / 3 kg n/a B 300 / BS 300 / 15 kg 25 spools = 375 kg (pallet) Eco-drum / 200 kg 2 drums = 400 kg (pallet)
Rod packagings	Box 10 kg Length 1.000 mm

ML CuSi3

Rod/Wire electrode for Copper

Typical composition in %	Al < 0,02 Si 2,80-4,00 Mn 0,50-1,50 Sn < 0,20 Zn < 0,40 Pb < 0,02 Fe < 0,50 P < 0,05 Others total < 0,50
Classification	ISO 24373 S Cu 6560 (CuSi3Mn1) DIN 1733 SG-CuSi3 Material No. 2.1461 BS 2901 Part 3 C 9 AWS A 5.7 ER CuSi – A
Base materials	CuZn5; CuZn10; CuZn15; CuSi2Mn; CuSi3Mn
Remarks	Filler wire for joining copper, copper-silicon and copper-zinc alloys. Suitable for joining of steel to copper and for surfacing of steel. High temperature and corrosion resistance. Very commonly used for galvanized steel.
Physical properties (Approx. values)	Electrical conductivity [$S \cdot m/mm^2$] 3-4 Density [kg/dm^3] 8,5 Solidus-Temperature [$^{\circ}C$] 910 Liquidus-Temperature [$^{\circ}C$] 1025 Tensile strength R_m [MPa] 330 - 370 Elongation A_5 ($L_0=5d_0$) [%] 40 Hardness [HB] 80 - 90
Welding position	PA, PB, PC, PE, PF
Shielding gas	I1, I2, I3 (Argon, Helium or Argon/Helium-mixtures)
Polarity	MIG =+, TIG -
Dimensions Ø	MIG-wires [mm] 0,8; 1,0; 1,2; 1,6; 2,0; 2,4; 3,2 TIG-rods [mm] 1,6; 2,0; 2,4; 3,2; 4,0
Wire packagings	Spools Packaging units S 200 / 5 kg n/a S 300 / 15 kg 25 spools = 375 kg (pallet) B 300 / 3 kg n/a B 300 / BS 300 / 15 kg 25 spools = 375 kg (pallet) Eco-drum / 200 kg 2 drums = 400 kg (pallet)
Rod packagings	Box 10 kg Length 1.000 mm