




CEWELD E CuMnAlNi

TYPE	Manganese aluminium bronze electrode developed for welding on DC+. High tensile strength alloy with good sliding properties.
APPLICATIONS	CuMnAlNi is designed for welding and overlaying of almost all bronzes but can also be used on cast iron and most kind of steels. Due to the high tensile strength and the very good sliding properties it is often used for surfacing of shafts, ship propellers, bearings, dies etc.
PROPERTIES	This alloy has exceptional corrosion resistance against several items such as seawater or other chemical attack when accompanied by erosion. Welding instructions: CuMnAlNi is only Weldable on DC + and has an easy removable slag. Use the normal standard welding techniques.

CLASSIFICATION	AWS	A 5.6: E CuMnNiAl
	EN ISO	17777: E Cu 6338
	F-nr	37
	W.Nr.	2.1368
	W.Nr.	2.1367

SUITABLE FOR	Joining brass, Bronze, and steel, Ship propellers, Dies, Shafts, Pump parts, Valves, UNS : C62300 - C63000, Mat.n: 2.0936, 2.0966, 2.0940, CuAl10Fe3Mn2, CuAl10Ni5Fe4, G-CuAl10Fe, CuNiAl UNS: C62300, C63000, C95200 Alloy MNA 13-3 (Cunial A).
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APPROVALS	No Approvals Found
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WELDING POSITIONS	  
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TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	Si	Mn	Fe	Al	Ni+Co	Cu
	1.1	12	3	7.5	2	Rem.

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	Hardness Brinell Hardness
	As Welded /		650	20	Avg. 220

REDRYING TEMPERATURE	140°C / 2 hr
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GAS ACCORDING EN 14175	
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E CUMNALNI 2,5 X 350MM	Type	KG/unit	EANCode
	Can	2,5	8720663408051
E CUMNALNI 3,2 X 350MM	Type	KG/unit	EANCode
	Can	2,5	8720663408075
E CUMNALNI 4,0 X 350MM	Type	KG/unit	EANCode
	Can	3	8720663408099