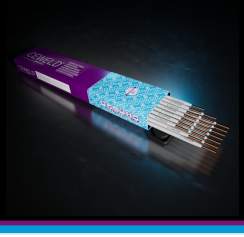


CEWELD E CuMnAlNi

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic coated manganese-aluminum-bronze stick electrode, developed for welding with DC+. Alloy with high tensile strength and good sliding properties. (E CuMnNiAl, E Cu6338)

APPLICATIONS

CEWELD® E CuMnAlNi is designed for welding and surfacing almost all bronzes, but can also be used on cast iron and most types of steel. Due to its high tensile strength and very good sliding properties, it is often used for build-up welding of slideways, bearings, dies and punches. Other applications include: Ship propellers, slide valves, valves, pumps, shafts, pipes, evaporators, contacts, Kaplan turbine blades, Francis turbines, Pellton wheels, etc.

PROPERTIES

CEWELD® E CuMnAlNi exhibits exceptional corrosion resistance to various influences, such as seawater or other chemical attacks associated with erosion. Welding instructions: CEWELD® E CuMnAlNi is only weldable with DC+ and has an easily removable slag. Preheating is only required for larger workpieces.

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 propellors, 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).

APPROVALS

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

Si	Mn	Fe	Al	Ni+Co	Cu
1.1	12	3	7.5	2.5	Rem.

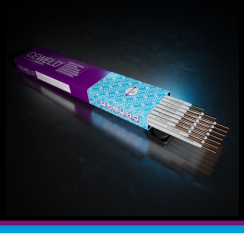
ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Hardness Brinell Hardness
As Welded /	400	660	16	Avg. 220

REDRYING TEMPERATURE

140°C / 2 hr

GAS ACCORDING EN 14175



CEWELD E CuMnAlNi

certilas® THE FILLER METAL SPECIALIST

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