



CEWELD E CuAl8

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. **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
F-nr	31
W.Nr.	2.0926

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 bronzes, Aluminum brass Cu22%, Zn2%Al, Manganese bronzes Cu+20-45%Zn+1-3%Mn, Silicon bronzes Cu+1-3.5%Si

APPROVALS No Approvals Found

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.

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2}	R _m	A ₅	Hardness Brinell Hardness
	As Welded /	MPa	MPa	(%)	
		200	450	24	Avg. 150

REDRYING TEMPERATURE 140°C / 1 hr

GAS ACCORDING EN 14175