



## MIG / TIG CuA9

## COPPER ALLOY

### DESCRIPTION

Aluminum bronze solid wire **GMAW (MIG)** or **GTAW (TIG)** for welding copper-aluminum alloys, heterogeneous assemblies like copper to steel, cast iron to copper and welding of galvanized steels.

### CHARACTERISTICS

- Conform to standard AWS A5.7 and ASME SFA 5.7, class ERcAl-A2
- Excellent weldability
- Excellent machinability
- The most versatile weld wire in the aluminum bronze family of alloys

### TYPICAL APPLICATIONS

Casting repair, general maintenance, galvanized sheet metal fabrications, and overlays on surfaces needing a bronze wearing surface.

### PROCEDURE

Remove any trace of oil, grease and dirt from the joint area. **Preheat copper and copper alloys between 200 and 600°C (450 - 1112°F) depending on the case.**

### MECHANICAL PROPERTIES

Tensile strength:	> 552 MPa (80 000 psi)
Yield strength:	> 242 MPa (35 000 lb/po <sup>2</sup> )
Elongation:	> 28 %
Hardness (as-welded):	130-160 BH

### WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas flow	Gas
GMAW MIG	0.9 mm (035")	22 - 26	150 - 200	40 to 50 CFH	100 % Argon or Argon + Helium
	1.2 mm (045")	25 - 29	200 - 260		
GTAW TIG	1.6 mm (1/16")	CC-		35 to 50 CFH	100 % Argon or Argon + Helium
	2.5 mm (3/32")				
	3.2 mm (1/8")				

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*Specialized welding alloys and technology. For technical assistance or for ordering:*