



TIG/MIG CUA10

COPPER ALLOY

DESCRIPTION

Solid GMAW (MIG) and GTAW (TIG) aluminium bronze alloy mainly used for welding aluminium bronze casting of similar composition. Also used for the build-up and repair of bearing surfaces of copper alloy parts.

CLASSIFICATION

AWS A5.7: ERCuAl-A3

TYPICAL APPLICATIONS

TIG/MIG CUA10 applications include, bearing overlays, hydraulic pistons, impellers, turbine runners, press rams, steel mill rolls, ceiling machine mandrels, breaker blocks, valve seats and parts, mill slippers, and cable sheaves.

MECHANICAL PROPERTIES

Tensile strength: > 91 000 psi (> 627 MPa)
 Yield strength: > 42 000 psi (> 290 MPa)
 Elongation: > 22 %

WELD METAL COMPOSITION (%)

Cu	Si	Al	Fe	Pb
Rem	0.10	11.0	3.5	0.02 max

WELDING PARAMETERS

Process	Size	Voltage	Amperage	Gas flow	Shielding gas
GMAW MIG	0.9 mm (035")	20 - 26	100 - 220	30 to 50 CFH	100 % Argon or Argon + Helium
	1.2 mm (045")	22 - 29	100 - 260		
GTAW TIG	1.6 mm (1/16")	Direct current Negative electrode		30 to 40 CFH	100 % Argon
	2.5 mm (3/32")				
	3.2 mm (1/8")				

Rév. : 21_08

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