

TCU AL8

TIG Welding Wire - Copper Alloys

Standards	
AWS/ASME SFA - 5.7	ERCuAl-A1
EN ISO 24373	S Cu 6100 (CuAl7)
TS EN ISO 24373	S Cu 6100 (CuAl7)
DIN M. No.	2.0921

Materials		
DIN	Material	ASTM
Cu Al 5	2.0916	C60600
Cu Al 8	2.092	C61000
Cu Zn 37 Al	2.0510	
G Cu Al 9	2.0928	

Properties and Applications

Aluminium bronze welding rod for GTA (TIG) welding of aluminium bronzes, high strength brass and surfacing of steel, gray cast iron used in machine building and in the chemical industry, as well as in shipbuilding. Alloy showing resistance to corrosion and erosion to sea water, with a very good metal to metal sliding properties. Suitable for also welding joints on corrosion resistant aluminium bronze or high strength brass pipes. Joining copper tubing to steel. Surface build-up on ship propellers, skid rails, bearing surfaces, bearings, valves, slide gates, fittings.



Typical Chemical Features of the Welding Wire

Type of Analysis	Mn	Ni	Al	Cu
Welding Wire	0.20	0.20	8.00	91.50

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Hardness (HB)
As welded	I1	200	430	40	100

* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions

PA

PB

PC

PD

PE

PF

Polarity:

Protection Gas:
I1

Welding Parameters & Efficiency

Diameter x Length (mm)
2.40x1000
3.20x1000

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
251021BKM2	2.40x1000	5 kg	5.20	1	5.20	Cardboard Tube
251021BKM2	3.20x1000	5 kg	5.20	1	5.20	Cardboard Tube

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.