



CEWELD E CuMnAlNi

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
W.Nr.	2.1368
F-nr	37

SUITABLE FOR Joining brass, Bronze, and steel, Ship propellers, 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

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded	400	660	16	220 HB

REDRYING

140°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E CuMnAlNi

E CUMNALNI 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663408051

E CUMNALNI 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663408075

E CUMNALNI 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	3	8720663408099