



CEWELD E CuMnAlNi

TYPE	Manganese aluminium bronze electrode developed for welding on DC+. High tensile strength alloy with good sliding properties.													
TOEPASSINGEN	CuMnAlNi is designed for welding and overlaying of almost all bronzes but can also be used on cast iron and most kind of steels. Due to the high tensile strength and the very good sliding properties it is often used for surfacing of shafts, ship propellers, bearings, dies etc.													
EIGENSCHAPPEN	This alloy has exceptional corrosion resistance against several items such as seawater or other chemical attack when accompanied by erosion. Welding instructions: CuMnAlNi is only Weldable on DC + and has an easy removable slag. Use the normal standard welding techniques.													
CLASSIFICATIE	<table><tr><td>AWS</td><td>A 5.6: E CuMnNiAl</td></tr><tr><td>EN ISO</td><td>17777: E Cu 6338</td></tr><tr><td>W.Nr.</td><td>2.1368</td></tr><tr><td>F-nr</td><td>37</td></tr></table>						AWS	A 5.6: E CuMnNiAl	EN ISO	17777: E Cu 6338	W.Nr.	2.1368	F-nr	37
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EN ISO	17777: E Cu 6338													
W.Nr.	2.1368													
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GESCHIKT VOOR	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).													
GOEDKEURINGEN														
LASPOSITIONS														
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	Si	Mn	Fe	Al	Ni+Co	Cu								
	1.1	12	3	7.5	2.5	Rem.								
MECHANISCHE WAARDEN	Heat Treatment	$R_{P0.2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness									
	As Welded	400	660	16	220 HB									

HERDROGEN 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