



CEWELD AA

CuAl12NiFe

TYPE Copper-Aluminum FCAW composite welding wire for cladding applications.

APPLICATIONS Cladding components undergoing metal to metal wear with high friction and or heavy surface loads on top of cast iron, steels and or bronzes. Ship propellers, Deep drawing dies for stainless steel, aluminium, magnesium and titanium parts. Sleeves, spindles, cable winches guides, gliding surfaces, pulling equipment. (Usually preheating 300°C prior to welding is recommended to reduce cracks).

PROPERTIES Special alloyed copper composite wire suitable for the Mig process.
The weld metal is a Cu-Al-Ni bronze with extreme high aluminium content.
Sound, pore free deposits with excellent sliding properties and low friction.

CLASSIFICATION EN ISO 14700: T Cu1

SUITABLE FOR Cu – Mn – Ni – Al bronze

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

Mn	Ni	Fe	Cu	Al
0.9	4.5	2.2	Rem.	12

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded				320 HB

REDRYING Not required

GAS ACC. EN ISO 14175 I1, I3



CEWELD AA CuAl12NiFe

AA CUAL12NIFE 1,2MM

Packaging	KG/unit	EanCode
D-300	13	8720663408938

AA CUAL12NIFE 1,6MM

Packaging	KG/unit	EanCode
D-300	13	8720663408952