

Aluminium Bronze

Classification

AWS.A5.7 ERCuAl-A2
UNS C61800

Description

Bronze Weld-A2 filler metal is an intermediate-strength aluminum bronze alloy used for welding aluminum bronze plate fabrications and for joining dissimilar metals such as cast iron, carbon steels, copper, bronze and copper-nickel materials

Application

Bronze Weld-A2 applications include wear surface reconstruction, casting repair, general maintenance, and galvanized sheet metal fabrication when high strength welds are required

Shielding Gas

Welding grade Argon or Argon/Helium mixtures

Chemical Composition of Solid Wire

Cu	Zn	Fe	Si	Al	Pb	Total Others
Balance	0.02 Max.	0.5 – 1.5	0.10 Max.	8.5 – 11.0	0.02 Max.	0.50 Max.

Typical Mechanical Properties of Weldmetal

Tensile strength	Yield strength	Elongation
540 MPa	270 MPa	28%

Packaging and Machine Settings – GMAW

Diam. (mm)	0.9	1.2	1.6
Spool (300mm)	13.6 kg	13.6 kg	13.6 kg
Volts	18-26	21-29	25-35
Current, A	120-210	160-290	220-380

Diam.	13.6kg Spool
0.9mm	CMWA209
1.2mm	CMWA212
1.6mm	CMWA216

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