

MT- CuAl 8

2.0921

Copper aluminium MIG/TIG welding wire.

Standard designation

EN ISO 24373	S Cu 6100
Material No.	2.0921
AWS/ASME SFA-5.6	ER CuAl - A 1

Main fields of application

Copper aluminium alloys, e.g. Albronce containing 7-9% Al, welded joints between copper and copper alloys and hardfacings on mild and low-alloy steels as well as cast iron.

Physical properties (typical values)

El.conductivity at 20°C [S · m/mm ²]	Thermal conductivity at 20°C [W/(m · K)]	Linear thermal expansions coefficient (20-300°C) [1/K]
8	65	17 · 10 ⁻⁶

Mechanical properties of all-weld-metal (typical values)

Gas shield Thermal treatment		I1 untreated	
Test temperature	[°C]	+20°C	
0,2 %-yield strength R _{p0,2}	MPa	200	
Tensile strength R _m	MPa	430	
Elongation A ₅	[%]	40	
Impact strength A _v	[J]	100	
Brinell-hardness HB 10/1000		140	

Average chemical composition of all-weld-metal (%)

Cu	Al
Bal.	8

Gas types applicable TIG

I 1

Gas types applicable MIG

I 1

TIG rod diameters, unit weights

Diameter [mm]	Length [mm]	Kg per box
1,60	1000	10,0
2,00	1000	10,0
2,40	1000	10,0
3,00	1000	10,0

MIG welding wire

Diameter 0,8mm 1,0mm 1,2mm 1,6mm

Welding positions MIG acc.to EN ISO 6947

PA, PB, PF

Welding positions TIG acc.to EN ISO 6947

PA, PB, PC, PE, PF

Current/Polarity TIG

= -

Current/Polarity MIG

= +