

CARBO S- CuMn13AI7 CARBO T- CuMn13AI7

International standards		S = solid wire	T = bare rod
	Material No.	2.	1367
	DIN 1733	SG-CuMn13Al7	SG- CuMn13Al7
	AWS A 5.7	ERCuMnNiAl	ERCuMnNiAl

Application notes Copper aluminium wire electrode with a high Mn content to be used for joining, surfacing and building up brass, bronze, copper and normal steels. The deposits have high mechanical quality values, are resistant to corrosion, cavitations, erosion, friction and seawater proof. Due to good resistance against seawater and general corrosion the electrode is used mostly in the ship building and chemical industry, specially when corrosion and erosion act together. The low friction rate of this alloy make it suitable for surfacing on slide faces, bearings, dies, ship propellers, valves, pumps shafts, pipings, evaporators, Kaplan-turbine-blades, Francis-turbines, Pelton-wheels.

Mechanical properties of all-weld-metal	Tensile strength R _m N/mm ²	Yielding strength R _{p0,2} N/mm ²	Elongation A ₅ %	Melting range	Hardness HB
(typical values)	900	650	10	945-985°C	200

Weld metal analysis		Cu	Mn	Fe	AI	Ni				
(typical, wt. %)		Base	13	2,5	7,5	2,5				
	S = solid wire					T = bare rod				
Gas types EN 439		11				11				
Current				= +				= _		
Diameter	mm	0,8	1,0	1,2	2. 1,6	1,6	5 2,0	2,4	3,2	4,0
Welding amps (A) min. (A) max.	(A) min.									
	(A) max.									
coils, weight		K300	15 kg.			10	kg./ carto	n		

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Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.