



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 border="0"> <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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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

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

Si	Mn	Fe	Al	Ni+Co	Cu
1.1	12	3	7.5	2	Rem.

MECHANISCHE WAARDEN

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded		650	20	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