



AWS A5.7 ER CuAl-A1
BS 2901 1990 Pt3: C28

Aluminium Bronze Filler Wire

CW-1810

DESCRIPTION & APPLICATION

MIG/TIG Filler Wire for the repair and reclamation of Aluminium Bronzes of similar composition. Suitable for the repair and reclamation of Bronzes, such as those used in Aluminium Die Casting, overlay of Steels to produce Spark-free surfaces with low Coefficient of Friction.

BASE MATERIALS

Aluminium Bronze
Overlay of steel

MECHANICAL PROPERTIES

200

UTS n/mm

N/A

YIELD 0.2%

~35

ELONG A5%

~100

HARDNESS HB

METAL WELD COMPOSITION %

Cu

BAL

Fe

0.25

Ni

0.5

Al

8.5

Zn

0.1

Pb

0.002

Mn

0.75

PACKAGING

15kg Spools (MIG)

DIAMETERS

0.8, 1.0, 1.2mm (MIG)

WELDING INSTRUCTIONS

Shielding Gas, Pure Argon or Argon/Helium. Preheat up to 300°C for large sections. Avoid maintaining temp 340-650°C for long periods, due to possibility of grain growth.