



AWS A5.7 ER CuNiAl  
 BS 2901 PT3: C26  
 DIN 1733: SG CuAl8Ni6

# Complex Aluminium Bronze Filler Wire

**CW-1840**

## DESCRIPTION & APPLICATION

MIG/TIG Filler Wire for the repair and reclamation of Nickel Aluminium Bronzes of similar composition. Also suitable for the joining of Cast Iron to Mild and low Alloy Steels and overlay of such material to provide sliding or bearing surfaces. Seawater-resistant, making the alloy suitable for marine applications, such as propellers, pumps and fittings. Low coefficient of friction.

## BASE MATERIALS

Aluminium Bronze of a similar composition. Spark resistant applications. Joining of Mild and Low Alloy Steel. Overlay and joining of Cast Iron. Overlay of Automotive Tooling to provide low friction draw edges.

## MECHANICAL PROPERTIES

~700

UTS N/MM

~400

YIELD 0.2%

~19

ELONG A5%

up to 230

HARDNESS HB

## METAL WELD COMPOSITION %

**Cu**

BAL

**Si**

0.04

**Al**

8.5

**Mn**

1.3

**Ni**

4.5

**Fe**

3.3

**Sn**

0.002

## PACKAGING

15kg Spools (MIG)  
 5kg Tubes (TIG)

## DIAMETERS

1.2, 1.6mm (MIG)  
 1.6, 2.4, 3.2 (TIG)

## WELDING INSTRUCTIONS

Shielding Gas Pure Argon or Argon/Helium. Weld with Dip transfer where possible. Pre-heat thick sections, but do not overheat base material. Maintain interpass temperature below 150°C. Fill all craters.

**For more details on welding of Copper Alloys, please see our Information Sheets.**  
**Visit:** [www.westbrookwelding.co.uk/downloads](http://www.westbrookwelding.co.uk/downloads)