



AWS A5.7 ERCuAl-A2~
BS 2901 1990 Pt3: C13

Aluminium Bronze Filler Wire

CW-1890

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 used in Aluminium Die Casting. Overlay of Steel to produce Spark-free surface with low Coefficient of Friction.

BASE MATERIALS

Aluminium Bronze
Overlay of steel

MECHANICAL PROPERTIES

200

UTS n/mm

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YIELD 0.2%

~35

ELONG A5%

~60 (work hardens)

HARDNESS HB

METAL WELD COMPOSITION %

Cu	Fe	Ni	Al	Zn	Pb	Mn
BAL	1.0	0.5	10.0	0.05	0.002	0.5

PACKAGING

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

DIAMETERS

0.8, 1.0, 1.2mm (MIG)
1.6, 2.4, 3.2mm (TIG)

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.

For more details on welding of Copper Alloys, please see our Information Sheets.
Visit: www.westbrookwelding.co.uk/downloads