



# CEWELD E CuAl8

**TYPE** Basic coated aluminium bronze electrode developed for welding on DC+. Good tensile strength alloy with good corrosion resistance.

**ANWENDUNGEN** CEWELD E CuAl8 is designed for joining steel with copper or its alloys and cladding steel or aluminium bronze.

**EIGENSCHAFTEN** The weld deposit offers good wear and corrosion resistance even in seawater. Welding instructions:  
- Preheating for sections >6 mm from 150 till 300 °C is recommended. Use the normal standard welding techniques.

**KLASSIFIKATION**

AWS	A 5.6: ECuAl-A2
EN ISO	17777: E Cu 6100A
W.Nr.	2.0926
F-nr	31

**GEEIGNET FÜR** Aluminium bronze, Cladding steel, Shafts, Gliding surfaces, Joining steel to, Aluminium Bronze or Copper, etc.  
**Mat.n:** 2.0916, 2.0920, 2.0928, 2.0460, 2.0932  
 CuAl5, CuAl8, G-CuAl9, CuZn20Al2, CuAl8Fe3,  
**UNS:** C60600, C61000, C68700, C61400,  
 Copper-beryllium alloys Cu+0.5-2%Be, Cu-Zn brasses, Aluminum brass Cu22%,  
 Zn2%Al, Manganese bronzes Cu+20-45%Zn+1-3%Mn, Silicon  
 bronzes Cu+1-3.5%Si

**ZULASSUNGEN**

**SCHWEISSPOSITIONEN**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

Si	Mn	Fe	Pb	Al	Cu
0.7	0.5	0.8	0.01	7.5	Rem.

**MECHANISCHE GÜTEWERTE**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	200	450	24	180 HB

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175**