



# 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**

AWS	A 5.6: E CuMnNiAl
EN ISO	17777: E Cu 6338
W.Nr.	2.1368
F-nr	37

**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 <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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