

ROALLOY-CuAl A2

BASIC ALLOY: CU, AL,
AWS/SFA-5.7: ERCUAL-A2

ALUMINUM BRONZE WELDING WIRE FOR TIG/MIG WELDING

KEY FEATURES:

ERCuAl-A2 aluminum bronze is the most versatile welding electrode in this family of alloys. It is intended for deposition with electric arc welding processes. It is excellent for building up or overlaying metal for wear and corrosion resistant surfaces. Weld deposits exhibit high mechanical properties, tensile strength, yield strength and hardness

APPLICATIONS

- Marine maintenance and repair
- wear surface reconstruction
- Tractor gear housings, idler pulleys, pickling hooks
- cast repair
- joining aluminum bronze of similar composition
- paper mill rolls, motor bases, tin platemill rolls
- bearings, bushings, pump housings
- condenser boxes, hydraulic pistons, brake drums
- impellers, valve seats, gears, mixer arms
- press rams
- ship propellers
- and lance heads

SHEILDING GAS:

- Welding with 100% Ar gas

WELDING NOTE:

All parameters are suggested as basic guidelines and will vary depending on join design, number of passes, and other factors

CHEMICAL COMPOSITION:

Si	Fe	Al	Zn	Cu	Pb	Others
0.10	1.50	8.50-11.00	0.02	Remainder	0.020	0.50

MECHANICAL PROPERTIES:

UTS (N/mm)	Proof strength (N/mm ²)	EL % (l=5d)	Hardness (HB)
420 Min.	---	20 min.	130-150

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR MIG WELDING)

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min	Spool packing 12.5 kg	Spool packing 15 kg
0.80	0.031	70-220	24-26	15-25	✓	✓
1.20	0.047	150-300	24-34	20-30	✓	✓
1.60	1/16"	150-350	28-36	20-30	✓	✓

DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR TIG WELDING)

Size (mm)	Size (inch)	Length (mm)	Length (Inch)	Current Condition (DC-)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	40-80	10-16	✓	✓
2.0	5/ 64"	1000	36"	50-100	12-18	✓	✓
2.4/ 2.5	3/ 32"	1000	36"	60-120	14-20	✓	✓
3.2	1/ 8"	1000	36"	100-150	16-24	✓	✓