

# ROALLOY-CuNiAl

NICKEL-ALUMINUM-BRONZE SOLID WELDING  
WIRE FOR TIG/MIG WELDING

BASIC ALLOY: AL, MG,  
AWS/SFA-5.7: ERCUNIAL  
ISO 24373: CUAL9NI5FE3MN2

## KEY FEATURES:

Nickel- aluminum- bronze cast and forge parts in shipbuilding (e.g. shippopeller), for power plants including valves, sifter, pumps, tube systems as well as for the apparatus engineering and food receptacle. Weld surfacing on steel and AlBz including multi alloys. The welding material is seawater-, corrosion- and wear- resistant (e.g. when seawater, cavitation and erosion are simultaneously affecting the welding material).

## APPLICATIONS

- shipbuilding (e.g. shippopeller)
- power plants including valves, sifter, pumps, tube systems
- the apparatus engineering
- Weld surfacing on steel and AlBz
- food receptacle

## SHEILDING GAS:

- Welding with 100% Ar gas

## WELDING NOTE:

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

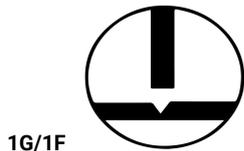
## CHEMICAL COMPOSITION:

Ni	Fe	Al	Mn	Si	Cu	Others	Zn
4.00-5.50	3.0-5.00	8.50-9.50	0.60-3.50	0.10	Balance	0.50	0.10

## MECHANICAL PROPERTIES:

UTS (N/mm )	Proof strength (N/mm2 )	EL % (l=5d)	Hardness (HB)
520 Min.	---	20 min	160-200

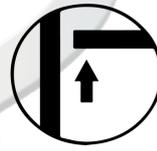
## WELDING POSITION



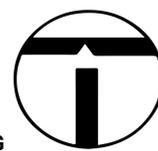
1G/1F



2G/2F



3G UP



4G

## 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	✓	✓