FONTARGEN A 215/8 W

Copper-aluminium welding rod

EN DIN 14640:	S Cu 6100 (CuAl8)
AWS A 5.7:	ERCuAl-A1
Material-no.:	2.0921

Composition, typical analysis (% w/w)**:**

Al	Ni	Mn	Fe	Cu
8	0.5	0.2	0.2	Remainder

Characteristics / Applications:

Corrosion- and seawater-resistant alloy with very good glide properties (metal-metal). A 215/8 W is very easy to handle and ensures a perfect weld in the root pass and a clean top surface. The seam is smooth and non-porous. Joint and build-up welding on aluminium-bronze, high-strength brass, steel and cast iron. For use in the machine-, chemical- as well as shipbuilding industries. Joint welding: Corrosion-resistant aluminium-bronze or high-strength brass pipework. Joining of copper conduits with steel. Joining of material numbers 2.0916, 2.0920, 2.0928. Preheat thick workpieces to 200 °C. Build-up welding: Building-up of ship propellers, kid rails, running surfaces, bearings, valves, slide gates, fittings, etc.

Mechanical properties of pure welding deposit (Min. values at room temperature):

Melting range:	1030 - 1040 °C
Tensile strength:	380 N/mm²
Yield strength (0.2 %):	200 N/mm²
Elongation (l=5d):	45 %
Hardness (Brinell):	11 HB
Electrical conductivity:	8 Sm/mm²
Thermal conductivity:	65/m • K
Specific gravity:	7.7 g/cm³
Linear expansion:	$17 \cdot 10^{-6}$ / K
Welding process:	TIG
Shielding gas (DIN EN 439):	I 1 (Argon)
Current mode:	DC (-pole) Recommendation: Utilization of flux F 200
Availability:	Diameter (mm): 2.0 Length (mm): 1000
Welding position:	according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
☒	☒	☒	☐	☒	☒	☐

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