FONTARGEN A 216 W

Copper-aluminium nickel rod

ISO 24373:	S Cu 6327 (CuAl8Ni2Fe2Mn2)
AWS A 5.17 :	ERCuNiAl
Material-no.:	2.0922

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

Al	Ni	Mn	Fe	Cu
8	2	1.5	1.5	Remainder

Characteristics / Applications:

Joint and build-up welding on multi-alloyed aluminium-bronze, for example material numbers: 2.0916, 2.0920, 2.0928, 2.0932, 2.0936, 2.0940, 2.0960, 2.0962, 2.0966, 2.0970, 2.0975, 2.0978 and 2.0980. Build-up welding on steel and copper alloys. Fusion welding between steel and aluminium-bronze (also multi-alloys). Suitable for welding (MIG brazing) of aluminium surfaced and galvanised steels. For use in shipbuilding, machine, apparatus and pump construction; for example ship propellers, pump casings, valve control casings and food containers. Preheating necessary only with large workpieces. For the first run of build-up welds on ferrous base material we recommend pulsed-arc welding.

The welding deposit is saltwater- and corrosion resistant as well as wear resistant. Well suited if at the same time subjected to wear by salt water, cavitation and erosion.

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

Melting range:	1030 - 1050 °C
Tensile strength:	530 N/mm²
Yield strength (0.2 %):	290 N/mm²
Elongation (l=5d):	30 %
Impact energy (ISO-V):	70 J
Hardness (Brinell):	140 HB
Electrical conductivity:	5 Sm/mm²
Thermal conductivity:	58 W/m • K
Linear expansion:	$17 \bullet 10^{-6}$ / 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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