

CARBO S- CuMn13Al7

CARBO T- CuMn13Al7

International standards

	S = massive wire	T = bare rod
Werkstoff No.	2.1367	
DIN 1733	SG-CuMn13Al7	SG- CuMn13Al7
AWS A 5.7	ERCuMnNiAl	ERCuMnNiAl

Application notes

Copper aluminium wire electrode with a high Mn content to be used for joining, surfacing and building up brass, bronze, copper and normal steels.

The deposits have high mechanical quality values, are resistant to corrosion, cavitations, erosion, friction and seawater proof. Due to good resistance against seawater and general corrosion the electrode is used mostly in the ship building and chemical industry, specially when corrosion and erosion act together. The low friction rate of this alloy make it suitable for surfacing on slide faces, bearings, dies, ship propellers, valves, pumps shafts, pipings, evaporators, Kaplan-turbine-blades, Francis-turbines, Pelion-wheels.

Mechanical properties of all-weld-metal

(typical values)

Tensile strength R _m N/mm ²	Yielding strength R _{p0,2} N/mm ²	Elongation A ₅ %	Melting range	Hardness HB
900	650	10	945-985°C	200

Weld metal analysis (typical, wt. %)

Cu	Mn	Fe	Al	Ni
Base	13	2,5	7,5	2,5

Gas types EN 439

S = massive wire

I1

T = bare rod

I1

Current

Diameter mm
Welding amps (A) min.
(A) max.

= +				= -				
0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0

coils, weight

K300 15 kg.

10 kg./ carton

Rev. 000