



## ECU AI8

Coated Electrode for Copper Alloys -

Standards	
AWS/ASME SFA - 5.6	ECuAl-A2
Properties and Applications	
Electrode depositing 8% Al containing aluminium bronze weld metal. Suitable for welding aluminium bronze base metals. Also widely used for surfacing of components subjected to metal to metal wear even in corrosive environments (acids, sea water, etc.) Used with DCEP.	


Materials		
DIN	Material	ASTM
Cu Al 5	2.0916	C60600
Cu Al 8	2.0920	C61000

Typical Chemical Values of Weld Metal				
Type of Analysis	Mn	Al	Cu	Fe
Weld Deposit	0.50	8.00	Remaining	0.50


Typical Mechanical Values of Weld Metal				
Test Condition	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Hardness (HB)
As welded	180	420	> 20	180

### Application Information


Welding Positions



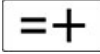
PA



PB



PC

Polarity: 

Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
3.25x350	80-110
4.00x350	100-140

### Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
15002NJEM2	3.25x350	67 AD	2.06	9	18.80	VAC Box
15002NQEM1	3.25x350	60 AD	1.91	6	10.40	Cardboard Box
15002QJEM2	4.00x350	49 AD	2.06	9	18.80	VAC Box
15002QKEM1	4.00x350	60 AD	2.52	6	15.40	VAC Box

### Storage & Re-Drying Information

It has to be dried at 350°C for 1 hour.  
 It can be dried maximum 5 times.  
 It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.



## EXPERIENCE THE CONVENIENCE OF EVERYTHING UNDER ONE ROOF

---

At Lascentrum, you can find everything you need regarding products for welding and safety. Lascentrum has been established in 1988 and now imports a complete range of welding consumables, gouging electrodes, gas welding & cutting equipment, welding blankets, safety products and accessories.

## CONTACT

---

Nieuwland Parc 1  
2952 DA Alblasserdam,  
The Netherlands

T:+31 (0)78 642 96 56  
F:+31 (0)78 642 96 86

[www.lascentrum.com](http://www.lascentrum.com)  
[info@lascentrum.com](mailto:info@lascentrum.com)

