

SM-CuAl A1 (TIG : ST-CuAl A1)

Conformances

AWS A5.7	ERCuAl-A1
EN ISO 14640	CuAl8
GB/T9460	SCu6100

Key Features

- Recommended for the welding of copper with Cu-Sn Alloy
- Best for the butt joining welding of brass with steel
- Pre-heat suggested for the large size Products and pulsed argon arc welding is recommended for multilayer hard facing on steel

Shielding Gas

Argon 100%

Typical Application

- Butt joining welding of copper with steel
- Machinery
- Shipbuilding

Chemical Composition (%)

Cu	Al	Fe	Mn	Ni	P	Pb	Si	Sn	Zn	Others
bal.	6.0-8.5	-	0.50	-	-	0.02	0.10	-	0.2	0.50

Mechanical Properties

Tensile Strength (Rm)	Elongation
380 ~ 450 N/mm ²	40 ~ 45 %

Applicable Joining Processes

Applicable Joining Processes

Alloy	UNS No.	Oxyfuel Gas Welding	SMAW	GMAW	GTAW	Resistance Welding	Solid-state Welding	Brazing	Soldering	Electron Beam Welding
ETP Copper	C11000-C11900	NR	NR	F	F	NR	G	E	G	NR
Oxygen-Free Copper	C102000	F	NR	G	G	NR	E	E	E	G
Deoxidized Copper	C12000-C123000	G	NR	E	E	NR	E	E	E	G
Beryllium-Copper	C17000-17500	NR	F	G	G	F	F	G	G	F
Cadmium/Chromium Copper	C16200-C18200	NR	NR	G	G	NR	F	G	G	F
Red Brass – 85%	C23000	F	NR	G	G	F	G	E	E	-
Low Brass – 80%	C24000	F	NR	G	G	G	G	E	E	-
Cartridge Brass – 70%	C26000	F	NR	F	F	G	G	E	E	-
Leaded Brasses	C31400-C38590	NR	NR	NR	NR	NR	NR	E	G	-
Phosphor Bronzes	C50100-C52400	F	F	G	G	G	G	E	E	-
Copper Nickel 30%	C71500	F	F	G	G	G	G	E	E	F
Copper Nickel 10%	C70600	F	G	E	E	G	G	E	E	G
Nickel Silvers	C75200	G	NR	G	G	G	G	E	E	-
Aluminum Bronze	C61300 C61400	NR	G	E	E	G	G	F	NR	G
Silicon Bronzes	C65100 C65500	G	F	E	E	G	G	E	G	G

E=Excellent G=Good F=Fair NR=Not Recommended

| Courtesy of American Welding Society Welding Handbook 8th Ed. Vol. 3 Part 1

Recommended Welding Amperage

SMAW (DCRP)

Diameter	Amperes*
3/32"	50-110
1/8"	90-160
5/32"	130-180
3/16"	150-225

GMAW (DCRP) Gas: 100% Ar or 75/25 Ar/He

Diameter	Voltage	Amperes*
.035"	20-26	100-200
.045"	22-28	100-250
5/32"	29-32	250-400
3/16"	32-34	350-500

GTAW (DCSP, ACHF) Gas : 100% Ar or He

Diameter	Amperes* (DCEN)	Amperes* (ACHF)
1/16"	70-120	70-150
3/32"	120-160	140-230
1/8"	170-230	225-320
5/32"	220-280	175-300
3/16"	280-330	200-320

*Use low range for iron- or nickel-based alloys; middle range for bronze alloys; high range for copper

Suggested Filler Metal Selection

Suggested Filler Metal Selections for Copper-based Alloy

	Copper	Phosphor Bronze	Silicon Bronze	Yellow (Naval) Brass	Manganese Bronze	Navy G	Red Brass	Copper Nickel	Nickel Al Bronze
Copper	Deox (538)								
Phosphor Bronze	PHB, Deox (538)	PHB, Deox (204)							
Silicon Bronze	PHB, Deox (538)	PHB, SB (66)	SB (66)						
Yellow (Naval) Brass	SB, PHB, Deox (538)	PHB (316)	AIB-A2, SB (66)	AIB-A2 (316)					
Manganese Bronze	PHB, Deox (538)	AIB-A2, PHB (204)	AIB-A2, SB (66)	AIB-A2, PHB (316)	AIB-A2, PHB, Ni Bronze (149)				
Navy G	PHB, Deox (538)	PHB (204)	AIB-A2, SB (66)	PHB (316)	AIB-A2, PHB (316)	AIB-A2, PHB (316)			
Red Brass	PHB, Deox (538)	PHB (260)	AIB-A2, SB (66)	PHB (316)	AIB-A2, PHB (316)	AIB-A2, PHB (316)	AIB-A2, PHB (204)		
Copper Nickel	AIB-A2, Deox (538)	PHB, AIB-A2 (204)	AIB-A2 (66)	AIB-A2 (66)	AIB-A2 (149)	AIB-A2 (66)	AIB-A2 (66)	CuNi67 ERcNi	
Nickel Aluminum Bronze	AIB-A2, Deox CuNiAl (538)	PHB (204)	AIB-A2 (66)	AIB-A2, CuNiAl (260)	AIB-A2 (149)	AIB-A2 (260)	AIB-A2 (316)	AIB-A2 (316)	CuNiAl (149)
Low Alloy Steel	AIB-A2 (538)	PHB, AIB-A2 (204)	AIB-A2 (204)	AIB-A2 (316)	AIB-A2 (204)	AIB-A2, PHB (260)	AIB-A2 (316)	AIB-A2 (204)	AIB-A2 (204)
Low Carbon Steel	AIB-A2 (538)	PHB, AIB-A2 (204)	AIB-A2 (66)	AIB-A2 (260)	AIB-A2 (66)	AIB-A2, PHB (316)	PHB (316)	AIB-A2 (66)	AIB-A2 (149)
Medium Carbon Steel	AIB-A2 (538)	PHB, AIB-A2 (204)	AIB-A2 (66)	AIB-A2 (260)	AIB-A2 (204)	AIB-A2, PHB (316)	AIB-A2 (316)	AIB-A2 (204)	AIB-A2 (204)
High Carbon Steel	AIB-A2 (538)	PHB, AIB-A2 (260)	AIB-A2 (204)	AIB-A2 (260)	AIB-A2 (260)	AIB-A2, PHB (316)	AIB-A2 (316)	AIB-A2 (260)	AIB-A2 (260)
Cast Iron	AIB-A2 (538)	PHB, AIB-A2 (204)	AIB-A2, SB (149)	AIB-A2 (316)	AIB-A2 (204)	AIB-A2, PHB (316)	AIB-A2, PHB (316)	AIB-A2 (204)	AIB-A2 (204)

Temperature in parentheses is the recommended preheat and interpass (Celsius) temperature.

Recommended Tungsten Electrodes for GTAW are 2% Thoriated, 2% Ceriated, 2% Lanthanum or E3 (EWG).

Notes: **PHB** = Phosphor Bronze
Deox = Deoxidized Copper
SB = Silicon Bronze

AIB-A2 = Aluminium Bronze A-2
CuNiAl = Copper Nickel Aluminum Bronze
CuNi67 = Copper Nickel 67

Standard Packaging

Packaging

Packaging Type	Image	Diameter	Weight	Remark
Rods		1.2 ~ 9.5 mm		<p>Length: 350 ~ 1000 mm</p> <p>Rod identification possible by stamping. Color for flux coated TIG rods: white, blue, yellow</p>
Spool		0.6 ~ 1.6 mm	1 ~ 15 kg	<p>Type: D100, D200, D300, K300, BS300</p>
Wood		0.8 ~ 2.4 mm	Max. 250 kg	
Drums		0.8 ~ 1.6 mm	100 ~ 250 kg	
Coils		1.6 ~ 6.0 mm	15 ~ 100 kg	<p>Outer θ : 450 ~ 650 mm</p> <p>Inner θ : 250 ~ 450 mm</p>