

GM 715

SOLID WIRE FOR WELDING STANDARD ALUMINIUM BRONZE ALLOYS

IDENTIFICATION

GM 715, ERCuAL-A2

CLASSIFICATION

AWS/SFA 5.7: ER Cu Al-A2

DIN 1733:SG-Cu Al10Fe, BS 2901:Pt3: Grade C13

DESCRIPTION

This wire deposits plain 9% aluminum bronze for welding similar 5 - 11% Al alloys. The wire can be used to weld range of copper - based alloys to themselves or to mild steel, cast irons and iron - base alloys. However, alloys containing chromium (stainless steels) should be avoided since chromium pick-up may cause embrittlement and cracking. For such applications special buttering procedures should be used. The wire can be used to overlay CMn steels and cast irons to give wear and corrosion resistant bearing surfaces

CHEMICAL ANALYSIS (RANGE) %

Al	Zn	Fe	Si	Pb	Cu
8.5 - 11.0	0.02 max	1.5 max	0.10 max	0.007 max	Remainder

MECHANICAL PROPERTIES (RANGE)

Tensile Strength (N/mm ²)
490 min

TYPICAL APPLICATIONS

- Aluminum bronzes: UNS C61400, BS CA 101-103, alloy D and others. Beryllium copper (Cu+0.5-2% Be). Closest approximation to strength. High zinc bronzes and manganese bronzes (20-45% Zn). Colour similar to bronzes. Silicon bronzes (1-3.5% Si) -see also 97CuSi (DS 15-07A).
- Corrosion resistant and spark resistant pumps, castings, machinery parts, heat exchangers for offshore, marine and mining equipment.

SHIELDING GAS : Pure Argon or Helium or Argon - helium

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5
1.2	12.5
1.6	12.5