

Classifications

DIN 8555	EN 14700
MSG-31-GF-250-C	T Cu1

Characteristics

Special copper-aluminium especially developed for the building up of aluminium bronze and parts subjected to metal to metal wear under high pressure.

Machinability:	Good
Oxy-acetylene cutting:	Cannot be flame cut
Deposit Overthickness:	Depends upon application and procedure used
Shielding gas:	Argon 50 % + Helium 50 %
Liner:	A Teflon liner is advised

Field of use

Ship propellers, valves, bearings

Typical analysis in %

C	Mn	Si	Ni	Al	Fe	Cu
0,02	0,9	0,1	4,2	10,5	1,5	balance

Typical mechanical properties

Hardness as welded: 260 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,6	200-250	27-29	20 max.	20-25