

BERCOWELD[®] A35 (AlBz35)

Cu-alloy wire electrode for MAG and MIG welding.

Standard designation ISO 24373 : Cu 6328 CuAl9Ni5Fe3Mn2

Composition (weight %)	Cu	: balance
	Al	: 8,50-9,50
	Ni	: 4,00-5,50
	Fe	: 3,00-5,00
	Mn	: 0,60-3,50
	Others	: max. 0,5

Physical standard data

Density	kg/dm ³	: 7,5
Melting range	° C	: 1015-1045
Thermal conductivity	W/m· K	: 20-40
Coefficient of linear mean expansion (20°C-300°C)	1/ K	: 19,3·10 ⁻⁶
Electrical conductivity	m/Ω·mm ²	: 3-4
Resistivity	Ω·mm ² /m	: 0,20-0,25

Mechanical properties of linear mean expansion

Heat treatment		non treated
Tensile strength	N/mm ²	: 690
Elongation	%	: 16
Brinell hardness	HB 2,5/62,5	: min. 200
Notched bar impact test	A _v (J)	: 68

Range of application

For the welding of nickel- aluminum- bronze cast and forge parts in shipbuilding (e.g. ship propeller), for powerplants including valves, sifter, pumps, tube systems as well as for the apparatus engineering and food receptacle. Weld surfacing on steel and AlBz including multi alloys. The welding material is seawater-, corrosion- and wear- resistant (e.g. when seawater, cavitation and erosion are simultaneously affecting the welding material).

Recommendation

Applicable inert gas

Argon 4.8/ 5.0/ 5.3/ 5.6/ 6.0

Make up

Diameter: 0,80 - 1,00 - 1,20 - 1,60 - and 2,40 mm.
Spools: D 300, H 370 and wire basket spools (acc. to DIN 8559).
Rods: 2,00 - 6,00 mm Ø x 1000 mm.
Further make ups on request.

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