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Aluminum Bronze A-2 Electrode

◆ INTRODUCTION

Aufhauser Aluminum Bronze A-2 Electrode has weld metal of higher tensile strength, yield strength, and hardness with a correspondingly lower ductility than the Aluminum Bronze A-1 (EC614). Used in ship-building, sea water applications, desalination plants, chemical industry, pump parts that are attacked by salt water (propellers, bearings, etc.).

◆ APPLICATIONS

- Repairing aluminum bronze and other copper alloy castings.
- High strength surfacing of wear- and corrosion-resistant bearing surfaces.

◆ CHEMICAL COMPOSITION

<u>Copper</u>	<u>Aluminum</u>	<u>Iron</u>	<u>Lead</u>	<u>Silicon</u>	<u>Other</u>
Remainder	6.50 – 9.0	0.50 – 5.0	0.02	1.50	*

Note: Copper contains Silver. All values are maximum percentage, unless shown in range. *Total Other elements (include Manganese, Nickel, Tin, Zinc) = 0.50 max

◆ PHYSICAL and MECHANICAL PROPERTIES

Tensile Strength	77,000 psi
Yield Strength	35,000 psi
Elongation, in 2 in.	27%
Brinell Hardness	110-130
<i>Hardness will vary depending on weld quality and welder expertise</i>	

◆ SPECIFICATIONS MEET or EXCEED

- AWS A5.6 Class E CuAl-A2
- ASME SFA 5.6 Class E CuAl-A2

◆ STANDARD SIZES AND DIAMETERS

<u>Diameters</u>	<u>Lengths</u>	<u>Amperage</u>
3/32	12"	80-100
1/8	14"	90-120
5/32	14"	120-140
3/16	14"	120-140

Copper and its alloys require a relatively high heat input with shortened welding time. Higher preheat temperatures and faster welding rates than for steel are necessary.