



SAFRA SF-Cu.Mn.13Al.7

A.W.S. A5.7:
ER Cu MnNiAl

DIN 1733:
SG-Cu Mn 13 AL 7
WERKS.2.1367

BS 2901 Pt.3: C22
EN 14640: S CuMn13Al7
S Cu 6338

DESCRIPTION

The alloy SAFRA SF-Cu.Mn.13Al.7 is a welding wire containing manganese, nickel, aluminium and bronze. This is suitable for joining or fixing cast metals and for welding base metals with similar compositions. Other applications include the resistance to using bronze-alloy-surfaces and surface applications on CMn steels and cast iron, which require bronze diffusion bonding. Coatings with this alloy allow a very high corrosion, erosion and cavitation resistance. Excellent in marine, power and chemical plants for the production of propellers, pumps and seawater devices.

CHEMICAL COMPOSITION

| | |
|--------------------|-------------|
| Al | 7,5 - 8,3 |
| Si | <0,05 |
| Mn | 12,0 - 14,0 |
| Ni | 2,0 - 2,5 |
| Sn | <0,05 |
| Zn | <0,15 |
| Fe | 2,0 - 3,0 |
| Pb | <0,02 |
| Cu | remainder |
| OTHERS TOTAL <0,40 | |

SHIELDING GASES FOR GMAW/GTAW

Argon: DIN 32526 I1
Gas flow rate: 14-18 L./min.

MECHANICAL CHARACTERISTICS:

| | |
|--------------------------------|-----------------------------|
| Tensile strength Rm: | 800 - 900 N/mm ² |
| Elongation L=5d: | 10%<= |
| Hardness: | 180 - 220 HB |
| Hardness after work hardening: | 200 - 240 HB |

Mechanical properties quoted above are approximate values, intended for guidance only.

AVAILABLE SIZES

MIG: 12,5 kg – 15 kg D300 or K300/KS300 Spools

D I A M E T E R O F T H E W I R E
1,2 mm - 1,6 mm