



ALUMINUM BRONZE-A2

Certifications:

AWS A5.7
AWS A5.7M:2007
ASME SFA A5.7

Features

- Alloy/AWS Class: ERCuAl-A2
- Current: AC-DCEP

Applications

- Used for welding aluminum bronze plate fabrications
- Joining dissimilar metals such as; cast iron, carbon steels, copper, bronze, and copper-nickel materials
- Surface reconstruction; cast repair; marine maintenance and repair

Diameters & Packages

Diameter	2 lb	10lb	30 lb	36lb	500 lb
0.035		✓	✓		
0.045	✓		✓		
1/16			✓	✓	✓
1/8				✓	

NOTE: All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes, and other factors.

NOTICE: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. The results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

Technical Specifications

Typical Chemical Composition:

Cu (including Ag)	Zn	Fe	Si	Al	Pb	Other
Remainder	.02	.50 - 1.50	.10	8.5 - 11	.02	.5

Recommended Weld Parameters:

Tig Welding Process (GTAW)

Diameter	Volts	Amps	Gas
1/16	0	75-120	100% Helium or 100% Argon 40-55 CFH
3/32	0	120-160	100% Helium or 100% Argon 40-55 CFH
1/8	0	170-230	100% Helium or 100% Argon 40-55 CFH

Mig Welding Process (GMAW)

0.035	20-26	70-120	100% Argon or 75% Argon, 25% Helium 45-55 CFH
0.045	22-28	120-160	100% Argon or 75% Argon, 25% Helium 45-55 CFH
1/16	29-32	250-400	100% Argon or 75% Argon, 25% Helium 45-55 CFH
3/32	32-34	170-230	100% Argon or 75% Argon, 25% Helium 45-55 CFH

Typical Mechanical Properties:

Tensile Strength	Yield Strength	Percent Elongation
79,000 psi	35,000 psi	24%