

SK CuAl10-G

high-alloyed steels

Classifications gas-shielded metal-cored wire

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

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [L/min]
1.6	200 – 250	27 – 29	20 max.	20 – 25

FCAW-G – gas-shielded cored wires

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