



# CEWELD E CuMnAlNi

**TYPE** Basic coated manganese-aluminum-bronze stick electrode, developed for welding with DC+. Alloy with high tensile strength and good sliding properties. (E CuMnNiAl, E Cu6338)

**APPLICATIONS** CEWELD® E CuMnAlNi is designed for welding and surfacing almost all bronzes, but can also be used on cast iron and most types of steel. Due to its high tensile strength and very good sliding properties, it is often used for build-up welding of slideways, bearings, dies and punches. Other applications include: Ship propellers, slide valves, valves, pumps, shafts, pipes, evaporators, contacts, Kaplan turbine blades, Francis turbines, Pellton wheels, etc.

**PROPERTIES** CEWELD® E CuMnAlNi exhibits exceptional corrosion resistance to various influences, such as seawater or other chemical attacks associated with erosion. Welding instructions: CEWELD® E CuMnAlNi is only weldable with DC+ and has an easily removable slag. Preheating is only required for larger workpieces.

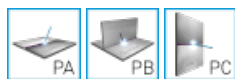
**CLASSIFICATION**

AWS	A 5.6: E CuMnNiAl
EN ISO	17777: E Cu 6338
W.Nr.	2.1368
F-nr	37

**SUITABLE FOR** Joining brass, Bronze, and steel, Ship propellers, Dies, Shafts, Pump parts, Valves, UNS : C62300 - C63000,  
**Mat.n:** 2.0936, 2.0966, 2.0940,  
 CuAl10Fe3Mn2, CuAl10Ni5Fe4, G-CuAl10Fe, CuNiAl  
**UNS:** C62300, C63000, C95200  
 Alloy MNA 13-3 (Cunial A).

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

Si	Mn	Fe	Al	Ni+Co	Cu
1.1	12	3	7.5	2	Rem.

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded		650	20	220 HB

**REDRYING** 140°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD E CuMnAlNi

E CUMNALNI 2,5 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663408051
E CUMNALNI 3,2 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663408075
E CUMNALNI 4,0 X 350MM	Packaging	KG/unit	EanCode
	Can	3	8720663408099