



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 7084 Aluminum Bronze Mig

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A5.7 ERCuAl-A2 DIN 1733: SG-CuAl10Fe
EN ISO 24373: Cu6180 CuAl10Fe

FEATURES & APPLICATIONS

APPLICATIONS:

7084 is a copper based filler metal containing about 1% iron used for gas-metal arc welding of copper, copper-nickel, brass, bronze, steel, galvanized steels and also cast iron. Most common applications would include marine maintenance and repair, ship propellers, pump housing, rigging jacks, piston heads, bearings and excellent for build-up or overlaying wear/corrosion resistance applications. Combinations of Copper or Aluminum Bronze base metals to steel are very common with this filler metal. Exhibits high mechanical properties and hardness.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Si	Pb	Zn	Fe	Al	Cu
0.10*	0.02*	0.02*	1.5*	8.0-11.0	Bal.

*maximum values

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	79,000 psi (545MPa)
Yield Strength	35,000 psi (241 MPa)
Elongation	28%
Brinell Hardness	140 HB

WELDING CURRENT & INSTRUCTIONS

Recommended Shielding Gas: 100% Argon

Welding Techniques: Insure welding surface is free of contamination.

Recommended Amperage Settings:

Diameter Inches (mm)	Volts	Amps
.035 (.9)	26-27	130-200
.045 (1.14)	27-28	185-245
.062 (1.6)	28-30	250-400