Technical Data Sheet
AMPCO-TRODE® 8N

Description and Application

AMPCO-TRODE® 8N aluminum bronze spooled wire and bare filler rod produce a deposit of high strength and good ductility with a nominal hardness of 140 Brinell as applied with the inert-gas processes. The addition of nickel improves corrosion resistance in heat and saltwater.

AMPCO-TRODE® 8N is especially suited for marine environments, joining, and cladding components undergoing metal to metal wear. It is ideal for ship propellers, shipbuilding, pumps, shafts and guide grooves.

Limiting Chemical Composition

% (filler metal)

Copper*	Balance
Aluminum	7.5 - 9.5
Iron	1.5 - 2.5
Nickel	1.8 - 3.0
Manganese	1.0 -2.5
Silicon	0.2 max.
Others	0.5 max.

*including silver

Mechanical Properties

(Nominal all-weld metal value)

Tensile Strength, ksi (MPa)	77 (530)
Elongation, % in 2" (51 mm)	30
BHN (3000kg) 1/4" (6.4mm) deposit	140

**Hardness will vary depending on quality of the weld and experience and knowhow of the welder.*

Specifications

DIN 1733, SG-CuAl8Ni2, W. Nr.: 2.0922

Typical Applications

Ship propellers	Bearing overlays
Pumps	Chemical industry
Breaker blocks	Guide grooves