



AMPCO-TRODE® 40

Manganese-Nickel-Aluminium-Bronze

Classifications

AWS A5.7 Class ER CuMnNiAl
ASME SFA 5.7 Class ER CuMnNiAl

ABS Certified: ER CuMnNiAl

Description

- AMPCO-TRODE® 40 manganese-nickel-aluminium bronze is for welding cast ship propellers conforming to MIL-B-21230, Alloy 2 for high resistance to corrosion, erosion and cavitation.
- AMPCO-TRODE® 40 also exhibits good ability to join dissimilar metals.
- Typical applications include ship propellers, marine components, welding cast iron, joining dissimilar metals.

Limiting chemical composition of all-weld metal (%)

Cu*	Al	Fe	Ni	Mn	Si	Others
Rem.	7.0-8.50	2.0-4.0	1.5-3.0	11.0-14.0	1.50 max	0.5 max

*Including silver

Mechanical properties (nominal all-weld metal values)

	Y.S. (MPa)	T.S. (MPa)	El. (% in 51mm)	Area Reduction %	BHN (3000 kg) (6.4 mm deposit)
Example	462	759	27	37	217

Sizes available

Diameter	(mm)	1.6	2.4	3.2	4.0	4.8
Length	(mm)	914	914	914	914	914
Tube size	(kg)	4.5	4.5	4.5	4.5	4.5

Recommended welding parameters

Refer to AMPCO® welding products brochure or website for recommended welding parameters.