



# AMPCO-TRODE® 40

Manganese-Nickel-Aluminium-Bronze

## Classifications

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

## Approvals

ABS Certified	: ERCuMnNiAl
---------------	--------------

## 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

## Typical Applications

Ship propellers, marine components, welding cast iron and joining dissimilar metals.

## Limiting chemical composition of all-weld metal (%)

Cu*	Al	Fe	Ni	Mn	Si	Other
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)

	Yield Strength	Tensile Strength	Elongation	Area Reduction	BHN (3000 kg)
	(MPa)	(MPa)	(% in 51mm)	%	6.4 mm deposit
Example	462	759	27	37	217

## Sizes available

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

## Recommended welding parameters

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