



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)	1.2	1.6
Spool size	(kg)	13.6	13.6

Recommended welding parameters

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