

copper alloys	DIN EN ISO 17672	AWS	composition in wt%				melting range °C	base material	furnace atmosphere
			Cu	Sn	Ni	other			
<b>ML 100</b>	Cu 110 / Cu 141	BCu-1b / BCu-1	100	-	-	-	1083 °C	steel, stainless steel, Ni-alloys	protective gas (H2, H2+N2, exo-gas), vacuum
<b>ML 103</b>			97	-	-	3 Fe	1083 °C	steel, stainless steel, Ni-alloys	protective gas (H2, H2+N2, exo-gas), vacuum
<b>ML 104</b>			96	4	-	-	960 - 1060 °C	steel, stainless steel, Ni-alloys	protective gas (H2, H2+N2, exo-gas), vacuum
<b>ML 106</b>			94	6	-	-	910 - 1040 °C	steel, stainless steel, Ni-alloys	protective gas (H2, H2+N2, exo-gas), vacuum
<b>ML 200</b>			88	12	-	-	820 - 990 °C	steel, stainless steel, Cu- alloys	protective gas (H2, H2+N2, exo-gas), vacuum
<b>ML 320</b>			80	20	-	-	800 - 890 °C	copper, Cu-alloys	protective gas (H2, H2+N2, exo-gas)
<b>ML CuNi3</b>	Cu 186		97	-	3	-	1085 - 1100 °C	steel, stainless steel, Ni-alloys	protective gas (H2, H2+N2, exo-gas), vacuum
<b>ML 409</b>			69		9	22 Mn	1000 - 1070 °C	steel, stainless steel, cemented carbide	protective gas (H2, H2+N2)
<b>ML 416</b>			60	-	20	20 Mn	1020 - 1080 °C	steel, stainless steel, cemented carbide	protective gas (H2, H2+N2)
<b>ML 422</b>			87	-	3	10 Mn	970 - 1030 °C	steel, stainless steel, cemented carbide	protective gas (H2, H2+N2)
<b>ML 425</b>			82	-	6	12 Mn	980 - 1080 °C	steel, stainless steel, cemented carbide	protective gas (H2, H2+N2)
<b>ML 937</b>	CuP 179		94	-	-	6 P	710 - 890 °C	copper, Cu-alloys	protective gas (H2, H2+N2, exo-gas)
<b>ML 986</b>	CuP 386		86	7	-	7 P	650 - 700 °C	copper, Cu-alloys	protective gas (H2, H2+N2, exo-gas)