

BRASS ALLOY CW510L Aqua Nordic®

CW510L Aqua Nordic® is a free cutting and forging brass in the form of rod. The alloy is lead free and is approved according to the 4MS list, use for drinking water applications, product groups B-D.

Composition

CW510L	Cu	Zn	Pb	Sn	Fe
Boundaries	57.0–59.0%	Rest	<0,1%	≤0.3%	≤0.3%

Al	Ni	Others
≤0.05%	<0.2%	≤0.2%

Standardization

The alloy is, according to international standards, equivalent in composition to

CW510L	CuZn42
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- SS-EN 12163, rod for general purposes
- SS-EN 12164, rod for free machining purposes
- SS-EN 12165, wrought and unwrought forging stock
- SS-EN 12166, wire for general purposes
- SS-EN 12167, profiles and bars for general purposes
- SS-EN 12168, hollow rod for free machining purposes

Structure type

The structure is α -phase and β -phase.

Application example

Rod:

Low lead brass details eg, for electrical applications and fittings. The alloy is very well suited for machining as well as hot-stamping.

Residual stress level

Rod must show no evidence of cracking after testing according to SS-ISO 6957 Copper alloys – “Ammonia test for determining resistance to stress corrosion”. Moderate stress according to the standard must be applied.

Dezincification resistance

The alloy is not dezincification resistant.

Heat treatment

Stress-relief annealing. Temperature 330-350°C. Time 1-2 hours (max). Stress-relief annealing should be carried out after all cold working which gives high residual tensile stresses in the material. It may also be justified after machining. This eliminates the risk of stress corrosion cracking caused by internal stresses.

Workability

Hot workability is very good.

Cold workability is good.

Mechanical properties

Listed below are some empirical values of the mechanical properties, according to the material condition "M" in the EN standard. These values are to be considered as guideline values for the delivered material.

Property	Value	Unit
Rm, Tensile strength	~450	MPa
Rp02, Yield strength	~130	MPa
A5, Fracture elongation	~40	%
Brinell hardness	~100	HB

Corrosion resistance

Copper is a relatively noble metal. Copper and its alloys therefore show little tendency to react with the environment. As a result, the copper materials generally have good corrosion resistance. However, corrosion may occur under adverse and unfavorable conditions. The type of corrosion which may occur depends on both the environment and the composition of the alloy.

Machinability

The alloy is possible to be machined in CNC-machines and cam-type automated machines but not as easy as traditional free cutting brass with high content of lead, like CW614N. The chips can be mixed with leaded alloys like CW617, CW614N and CW602N on the return.

AquaNordic® bar give lower cutting forces, less vibrations, less stickiness, better chip breaking and less burr formation compared to low leaded brass with the same content.

Tooling and cutting data: PVD-coated carbide, according to ISO-group K10. The given values vary according to the current machine tool, the cutting tool and type of operations

Cutting data	PVD-coated carbide ¹⁾	PVD-coated HSS
Rake angle γ_o	15-25°	15-35°
Clearance angle α_o	6-11°	6-14°
Cutting speed v_c	150 m/min or faster	100 m/min or faster
Feed f_n	0,05-0,20 mm/edge	0,05-0,20 mm/edge
Chip breaker	Type MM or ground ²⁾	Ground on rake face
PVD-coated tools	TiAlN	Low friction type
Coolant	Oil or emulsion	Oil or emulsion

1. Uncoated carbide can be used efficiently when the chip breaking properties are critical. A thick and more brittle chip is achieved but also higher cutting forces in comparison to cutting with coated carbide. CVD-coated carbide is not recommended, it has often to large edge radius (blunt).

2. Chip breaker is needed in most turning applications. This breaker should be relatively open. If the chip breaker is too narrow, the cutting forces will be higher than necessary.

Welding and brazing

The following applies to the different welding methods:

Welding method	Suitability	Comment
Fuse welding and resistance welding	Poor	Cannot be carried out with good results.
Braze welding	Poor	Cannot be carried out with good results because of the minimal difference between the melting temperature of the base metal and the working temperature of the solder.
Brazing (hard soldering)	Satisfactory, can be carried out with a silver solder and silver-phosphorus-copper solder	Difficult to carry out with a phosphorus-copper solder and cannot be carried out with satisfactory results with a brass solder (see Braze welding).
Soldering	Excellent	Very easy to carry out.

Surface treatment

Mechanical surface treatment such as grinding, brushing, blasting and polishing is carried out by conventional methods.

Pickling (non-oxidizing pickling) is suitably carried out with diluted sulphuric acid at room temperature.

Pickling to a metallically clean surface (oxidizing pickling) is suitably carried out in a pickling bath containing oxidants such as peroxide, nitric acid or dichromate. For pickling to a high gloss, baths containing nitric acid are mainly used.

Chemical and electrolytic polishing is easy to carry out with mixtures of concentrated acids, e.g. phosphoric acid, nitric acid and acetic acid.

Polishing is suitably carried out with commercial cleaning products for copper.

Dark dyeing is easy to carry out by wet chemical methods, dark sulphide or oxide layers being obtained.

Varnishing with clear varnish means that the appearance obtained after cleaning or dyeing, for example, is retained for a long time. Clear varnishes containing a discoloring inhibitor are available for demanding applications.

Metallization (metallic surface coating) is easy to carry out.

Recycling and Environment information

AquaNordic®, with a lead content less than 0,1% is not only approved in the environment classification system as BASTA, Byggvarubedömningen and Sunda Hus, furthermore also in an international level by the EU, through 4MS composition list, and by the American authority. The alloy fulfills all for the moment known demands.

All returns from this alloy can be handled without any restrictions of mixing and can therefore be used as a base of all our alloy alternatives.