



BRONZE

NON FERROUS (Cu Alloys)



Stick Electrode specially for the Welding of copper and bronze

CLASSIFICATION : AWS A/SFA 5.6

IS 8666

E CuSn-A

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KEY FEATURES :

- Copper-Tin electrode
- Due to high heat conductivity of Cu alloys, preheat of 260-370°C is recommended for heavy sections
- Typical 93% Cu-6% Sn deposit
- No preheat is required on thin sections and ferrous base material

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Welding of Copper or Bronze to steel
- Impeller blades, Valve seats
- Brass, Galvanized iron, Malleable Iron
- Ship propellers, Bearings, Bushings
- Cast iron welding where colour match is not necessary
- Joining dissimilar metals such as mild steel to phosphorus bronze and brass

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	Cu	Sn	P
Typical	94.8	5.0	0.2
Specification	92.0-96.0	4.0-6.0	0.10-0.35

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Typical	As Welded	275	24
Specification		240 min.	20 min.

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 350	40-70	1	10	10
3.15 x 350	80-110	1	10	10
4.0 x 350	110-160	1	10	10