



BRONZE

NON FERROUS (Cu Alloys)

AWS A/SFA 5.6 **ECuSn-A**

CLASSIFICATION:

ISO 17777

E Cu S180 (CuSn 5P)

IS 8736

E CuSn-A

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

APPROVALS: CE

TYPICAL APPLICATIONS:

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


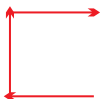
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

Cu	Sn	P
94.8	5.0	0.2

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 2.5 x 350 3.15 x 350 4.0 x 350	Amperage, A 40-70 80-110 110-160	 DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
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Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.