

CAST BRONZE

A thin coated electrode intended for welding of Copper and Copper-Tin alloys

CLASSIFICATION : AWS/SFA-5.6: E CuSn-C

CHARACTERISTICS : A thin coated electrode intended for welding of copper and copper-tin alloys. Welding Suitable copper or Bronze to steels. For obtain best results, used short arc and control interpass temperature.

APPLICATION :

- 1) Suitable for welding of Cast-Irons without preheat if machinability is not required.
- 2) Also suitable for cladding,
- 3) welding suitable for Bushes, Brass parts, Valve seats, Bearing, ship propellers, Malleable Iron, Galvanized Iron, Impellers Blades,

RE-DRY CONDITION : Re-Dry the electrode at 150°C for 1 hour.

WELDING TECHNIQUES:

While welding copper or bronze, the work piece should be preheated to approx. 300°C. But in no case the working temperature should reach 400°C or above as this will result in hot shortness. When welding large jobs maintain the interpass temperature of 300°C.

ALL WELD CHEMICAL COMPOSITION %

| Copper | Sn | P |
|---------|-------|-------------|
| Balance | 7 - 9 | 0.05 - 0.35 |

ALL WELD MECHANICAL PROPERTIES:

| UTS | EL % |
|----------|---------|
| 280 Min. | 20 Min. |

WELD METAL HARDNESS:

| |
|------------|
| Hardness |
| 85-100 HBS |

DIEMENSION, CURRENT CONDITION & PACKING DATA

| Size (mm) (Dia) | Size (inch) (Dia) | Current Condition (DC+) Amps | Wt. of /pkt. | Wt. of Case |
|--------------------|----------------------|---------------------------------|--------------|-------------|
| 2.50 / 2.40 | 3/32" | 40-70 | 2 | 10 |
| 3.15 / 3.20 | 1/8" | 70-100 | 2 | 10 |
| 4.00 | 5/32" | 110-150 | 2 | 10 |

Customer packing on request.