BRONZE

CLASSIFICATIONS

AWS A/SFA 5.6	ECuSn-A
IS 8666	E CuSn-A

IDENTIFICATION: Brand Printed

CHARACTERISTICS

An electrode specially designed for the welding of Copper and Bronze. The core wire is of Phosphor-Bronze. The weld metal contains approximately 93% copper, 6% tin and 0.20% phosphorus for complete deoxidation. Due to high heat conductivity of copper alloys, preheat of 260-370^{0}C is recommended and maintained throughout the welding operation on heavy section. No preheat is required on thin sections or on ferrous base material.

CURRENT CONDITIONS: DC (+)

4.0	3.2	2.5
110-160	80-110	40-70

WELDING POSITIONS

F & H Fillet

REDRYING CONDITIONS

300^{0}C for 1 hour (Optionally also available in vacuum-packed condition.)

TYPICAL APPLICATIONS

Suitable for welding Copper or Bronze to steel and for cast iron where a machineable deposit and colour matching is not necessary. Ship propellers, bearings, bushings, impeller blades, valve seats, brass, galvanised iron, malleable iron and dissimilar metals, such as mild steel phosphorus bronze and brass.

WELD METAL CHEMISTRY, (%)	
Cu -	92.0 - 96.0
Sn -	4.0 - 6.0
P -	0.10 - 0.35

MECHANICAL PROPERTIES - ALL-WELD		
Condition	**UTS** MPa	**% Elong.** (L=4xd)
As-welded	240 min.	20 min.

PACKING DATA			
Dia., mm	4.0	3.2	2.5
Length, mm	300	300	300
Wt. per carton, kg	1	1	1
Cartons / box	10	10	10
Net wt per box, kg	10	10	10