



DESCRIPTION

Electrode with special basic coating

It's particularly suitable for welding and recharging of phosphorous bronze or similar, brass and for recharging cast iron and carbon steel. It is used for the construction of pump blades, turbines, parts subject to wear, such as sliding guides, sliders, seats of valves, for repairing foundry and plating defects on tough steel to sea water. The higher tin content increases strength and wear resistance and increases the solidification temperature range during deposition of the weld metal (lower preheating to about 200°C is required).

SPECIFICATIONS

| | | | |
|-----------|---------|----------------|--------------------|
| AWS A5.6 | ECuSn-C | DIN 1733 | CuSn7 |
| Shielding | - | Positions | PA, PB, PC, PD, PF |
| Current | DC+ | Packaging Type | Carton box |

ASME QUALIFICATIONS

| | |
|--------------|----|
| F-No (QW432) | 33 |
| A-No (QW442) | - |

HARDNESS

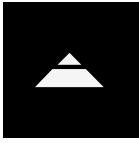
90HB

| CHEM. COMP. % | DEFAULT | MECHANICAL PROPERTIES | MIN. PER STANDARD | PRODUCT | |
|---------------|---------|---|-------------------|------------|-------------|
| Mn | 0.1 | Tensile strength R _m MPa | 280 | 340 | |
| Sn | 8 | Yield strength R _{p0.2} MPa | - | 140 | |
| P | 0.2 | Elongation A (L ₀ =5d ₀) % | 20 | 40 | |
| | | Impact Charpy ISO-V | - | - | |
| | | Impact Charpy ISO-V | - | - | |
| | | WELDING PARAMETERS | 2.5 mm | 3.2 mm | 4.0 mm |
| | | Ampere | 55A - 60A | 80A - 90A | 100A - 120A |
| | | Voltage | - | - | - |
| | | Packaging | pcs/kg | pcs/kg | pcs/kg |
| | | Packaging Type | Carton box | Carton box | Carton box |

NOTES

Pcs/kg is indicative, actual number may vary ± 5%.





CuSn

DESCRIPTION

APPLICATION

CuSn is used for welding a wide range of copper-based alloys, both with each other and with C-Mn steels or cast iron. It is also ideal for repair and joining of castings. When a low dilution is obtained, the material is suitable for overlays aimed at providing support surfaces and/or corrosion-resistant coatings on steel components, such as shafts and other mechanical parts. However, it is not suitable for stainless steels because the chromium released during the process can cause embrittlement. Tin bronze welding metal tends to stasis due to its wide melting range. Preheating to approximately 200 °C can improve fluidity in welding thick sections. To prevent hot cracking, it is advisable to keep the interpass temperature below 200 °C.

ALLOY TYPE

Tin bronze alloy wire for welding similar tin bronze (phosphor bronze) alloys.

MICROSTRUCTURE

A multi phase copper base structure with complex eutectoids.

MATERIALS

Tin bronze up to 10%Sn+0.5%P. Cu + 20-25%Sn. Cu + 40%Zn, manganese bronze.



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