Product Data Sheet

E 'Manual metal-arc welding'

OK 94.25

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
A-C Thorsson	P-O Oskarsson	Tapio Huhtala	EN007388	EN006930	2016-10-11	1 (2)

REASON FOR ISSUE

Classification standard DIN 1733 replaced by EN ISO 17777. Additional elements added to chemical composition.

GENERAL

Electrode for welding copper and bronzes, especially tin-bronzes. It is also suitable for cladding steels and for smaller repair work in weldable cast irons.

Polarity: DC+

Alloy Type: Copper alloy

Coating Type: Basic

WELDING POSITIONS

1 2 3 4

CLASSIFICATIONS Electrode

EN ISO 17777	E Cu Z (CuSn7)

APPROVALS

Seproz	UNA 272581

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
Si		0.5
Mn		0.50
P		0.20
Cu	91	94
Al		0.1
Sn	6.00	7.70
Pb		0.02
Zn		0.2
Fe		0.2
Others tot		0.5

MECHANICAL PROPERTIES OF WELD METAL

	ISO
	As welded
Properties	**Typ**
Rp0.2 (MPa)	235
Rm (MPa)	330-390
A5 (%)	25
Z (%)	30
Charpy V at 20°C (J)	25
Charpy V at 0°C (J)	20

Comments:

Hardness about 95 HB.

(Preheat and interpass temp. 300 °C.)

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ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding
Ø x Length	Min	Max								Positions
2.5 x 350	60	90	1.8	95	0.71	77.0	1.20	39	22	1,2,3,4
3.2 x 350	90	125	3.0	95	0.72	46.0	1.90	40	24	1,2,3,4
4.0 x 350	125	170	4.5	95	0.74	30.5	2.90	41	25	1,2,3,4

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)

OTHER DATA

Redrying 300 °C, 2h.