



BRONZE ALLOY

CAST IRON ELECTRODE

CLASSIFICATION :

AWS / A 5.6 : E Cu Sn A

CHARACTERISTICS :

A thin coated electrode intended for welding of copper and copper-tin-alloys. Best suited for joining copper or bronze to steels. Can also be used for welding of cast irons without preheat if machinability is not required. Suitable for cladding also. To obtain best results, use short arc and control interpass temperature.

APPLICATIONS :

- * Bushes
- * Valve seats
- * Ship Propellers
- * Malleable Iron
- * Brass parts
- * Bearings
- * Impellers Blades
- * Galvanized iron

RECOMMENDATIONS :

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.

**CHEMICAL ANALYSIS
OF WELD-METAL (%) :**

	Mn	Cu	Sn	P
	0.70 max	93-96	4.0-6.0	0.10-0.35

CURRENT CONDITIONS : USE DC (+) ONLY

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	40-70	70-100	110-150	160-200



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