

Masterweld CuSn-C

■ **Description & Applications:**

A versatile coated electrode which deposits a tough overlay of fully deoxidised bronze. Designed for joining and overlaying steels, cast irons, malleable iron, bronzes, brass and copper based metals. Due to the high thermal conductivity of copper alloys, pre-heating is advisable particularly if heavy sections are involved. The electrode is recommended for overlaying and building up bearing surfaces, bushes, impellor blades, valve seats, etc.

■ **Related Specification:**

AWS A5.6 E Cu Sn C
DIN 1733 El Cu Sn7

■ **Typical All Weld Metal Chemical Analysis %:**

Mn	Cu	Sn
0.4	91.0	7.5

■ **Typical All Weld Metal Mechanical Properties:**

As Welded

0.2% Proof Stress	310 N/mm ²
Ultimate Tensile Strength	465 N/mm ²
Elongation	20 %

■ **Current:**

AC/DC (+).

■ **Sizes Available and Recommended Amperages:**

2.5mm	3.2mm	4.0mm
60-80	80-130	130-180

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 110°C before use.