



Selectarc Cu115

Copper Tin Electrode
For DC

Classification

AWS A5.6 : E CuSn-C
UNS : W60521

DIN 1733 : EL-CuSn7
Material N° : 2.1025

Description & Applications

Basic coated electrode for welding copper tin bronzes (Cu-Sn 6-8%) and brasses (Cu-Zn) in some cases too. Also used for dissimilar joints. Selectarc Cu115 is recommended for repairing wrought bronzes (Cu-Sn), for surfacing on brasses, steels and cast iron. The deposit is resistant to salt water corrosion.

Main applications: Construction of equipment for the chemical industry and petrochemical industry, naval constructions and installations for sea water desalination, repair works.

Base materials

UNS	DIN	Material N°
C50700	CuSn2	2.1010
C51100	CuSn4	2.1016
C51900	CuSn6	2.1020
C52100	CuSn8	2.1030
	CuSn6Zn	2.1080
C52400	G-CuSn10	2.1050

Typical Weld Metal Composition (%)

Sn	Mn	Fe	P	Cu
7.0	0.9	0.15	0.1	Rem.

All Weld Metal Mechanical Properties

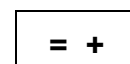
R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
120	300	>20	110 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	70-90	90-110	110-130

Redrying 2 h at 150°C. Joints to weld must be clean, exempt from grease, cracks. Guide electrodes with a slight declination (10-20°) inclined in direction of travel). Weld with a short arc. To improve degassing of the deposit, adopt a low welding speed. Heavy pieces (sections above 6 mm) have to be preheated to 150-300°C.

Ind.12



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