



# Selectarc Cu116

*Basic coated Cu-Al  
Bronze Electrode*

## Classification

AWS A5.6 : ~E CuAl-A2      DIN 1733 : EL-CuAl9  
UNS : W60614

## Description & Applications

Basic coated electrode for joining and surfacing on aluminium bronzes with up to 10%Al and for dissimilar joints between steels and CuAl-bronzes. Also recommended for overlays on cast iron, steels and copper alloys. Excellent weldability, stable arc, less spatters, easy to remove slag.

**Main applications:** Ship building, sea water applications, desalination plants, chemical industry, pump parts which are attacked by salt water (propellers, bearings...).

Base materials	UNS	Alloy	DIN	Material N°
	C60600		CuAl5	2.0916
	C61000		CuAl8	2.0920
	C68700	Yorcalbro	CuZn20Al2	2.0460

## Typical Weld Metal Composition (%)

Al	Mn	Fe	Cu
8.0	1.0	0.7	Rem.

## All Weld Metal Mechanical Properties

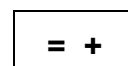
R <sub>p0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
180	420	>20	180 HB

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x350	3,2x350	4,0x350
Current	( A )	80-100	90-120	120-140

Redrying 2 h at 250°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 150-250°C.

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