

Basic coated MMA electrode with a bronze core wire for the welding of phosphor bronze and copper alloys. Suitable also for joining brasses and in some cases for welding them to cast iron and carbon steels. Postweld heat treatment may not be necessary, but is desirable to obtain maximum ductility, particularly if the weld metal is cold worked. Efficiency 100%.

### Classification

AWS A5.6: E CuSn-C

### Approvals

### Grades

### Analysis of all-weld metal (Typical values in %)

| C | Mn | Si | P       | S | Cr | Ni | Mo | Nb | Fe     | Cu  | Sn |
|---|----|----|---------|---|----|----|----|----|--------|-----|----|
| - | -  | -  | ≤ 0.350 | - | -  | -  | -  | -  | ≤ 0.25 | Rem | 8  |

### All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>A5 (%) | Impact Energy<br>ISO - V (J) | Hardness |
|----------------|-------------------------------------|---------------------------------------|----------------------|------------------------------|----------|
|                | -                                   | ≥ 280                                 | ≥ 20                 | -                            | 80-100   |

### Materials

2.1010; 2.1016; 2.1020; 2.1030; 2.1080; 2.1050

UNS C50700; UNS C51100; UNS C51900; UNS C52100; UNS C52400

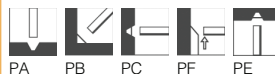
### Storage and redrying

Keep dry and avoid condensation.

Re-dry at 300-350 °C for 2 hours, 5 times max

### Current condition and welding position

**DC+; AC**



### Packaging data

| Diameter<br>(mm) | Length<br>(mm) | Current<br>(A) | Electrode<br>average weight (g) | Weld metal weight<br>per electrode (g) |
|------------------|----------------|----------------|---------------------------------|--|
| 2,5              | 300            | 50-70          | 15,7                            | 9,0                                    |
| 3,2              | 350            | 60-90          | 29,7                            | 17,8                                   |
| 4,0              | 350            | 120-140        | 45,8                            | 27,5                                   |