

Coating type:

Basic

Current:



Tip colour:

Gold

Welding positions:



Printing:

E CuSn / C Bronsil

Bronsil is our basic coated tin-bronze electrode for joining and surfacing copper and copper alloys, phosphor- and tin-bronzes as well as copper-clad plates in mechanical and plant engineering and shipbuilding. The electrode is also suitable for cladding steel and minor repair jobs in cast iron and C/Mn steel. Typical applications include repairing rotors and ship screws.

Base materials to be welded:

- Tin-bronze alloys CuSn 2, CuSn 6, CuSn 8, CuSn 6 Zn
- WNr. 2.1010, 2.1020, 2.1030, 2.1080

Applications:

- Shipbuilding & Offshore
- Repair & Maintenance
- Process Industry

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	-	-	Tinbronze 94-6	-	-

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Sn	Fe	Mo	Cu	Nb	V	Al
	1,50	0,50	0,010	0,15	7,50	0,20		Bal.			

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Hardness
As welded	≥ 200	≥ 280	≥ 25	≥ 100 HB

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
3,2	350	34,5	80-100
4,0	350	52,6	100-120