

BRONWELD Cu

Electrodes MMA [SMAW]

Stopy miedzi

CLASSIFICATION: DIN 1733 : E CuMn2 AWS A-5.6 : E Cu W.Nr. : 2.1363	APPROVALS:	APPLICATION: Hardfacing and repairing Metallurgy (Steelworks)
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- High electrical conductivity.
- High corrosion resistance.
- Weld metal free of porosity and cracks, well deoxidized.



Base material

UNS	W Nr.	DIN	PN
C10100	2.0040	OF-Cu	C103
C11000	2.0060	E-Cu	M1E
C10300	2.0070	SE-Cu	
C12000	2.0076	SW-Cu	M1R
C11022	2.0080	F-Cu	
C12200	2.0090	SF-Cu	M2R
C12500	2.0100	D-Cu	
	2.0110	SD-Cu	
C14200	2.0150	SB-Cu	
	2.0170	SA-Cu	

Typical chemical composition %

Si	Mn	Cu	Sn
0,25	2,5	96,0	0,70

Typical mechanical properties

Tensile strength Rm [N/mm²]	200
Elongation A5 [%]	app. 28%
Hardness	40-60HB /
Coating type	basic
Welding current	
Welding positions	
Redrying	300°C / 2 h

blend as little into the steel as possible.

Welding parameters and packing

Welding surfaces must be absolutely clean. The base material should be preheated to approximately 300-600°C depending on the thickness of elements to be welded. The electrode should have the largest possible diameter that can be used for the joint elements. Keep the arc as short as possible. Insulate the welding area from heat loss. Large expansion and contraction deformations must be taken into account, as they may cause cracks. When joining copper and its alloys with steel,

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/lot
2,5	300 /	40-50	5,0	20,0	11
3,2	350 /	80-120	5,0	20,0	11
4,0	350 /	120-150	5,0	20,0	11
5,0	350 /	130-190	6,0	30,0	11

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