

ROYAL BRONZE

AWS / SFA 5.6 E Cu Sn - A

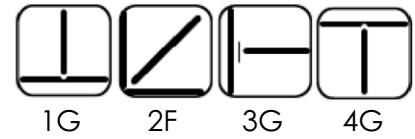
Applications

Suitable for welding copper and bronze to cast iron steel where colour matching is not essential, bearing bushings, impeller blades valve section.

Characteristics on Usage

It is a 94% copper contain light coated electrode, specially develop for the welding of Copper and Bronze. The weld metal gives 93% copper 6% tin and 0.20% phosphorous for complete deoxidation. Maintain preheat and inter pass temperature from 250 °C to 350 °C during the welding operation on heavy section.

Welding Positions



CUTTING & GOUGING

Chemical Composition Of Weld Metal

P%	Cu %
0.35 Max	92.0 – 96.0

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 X 350/ 450	2	10	4.40	22.05	50 - 80	DC (+)
3.20 X 350/ 450	2	10	4.40	22.05	80 – 110	
4.00 X 350/ 450	2	10	4.40	22.05	110 – 160	
5.00 X 350/ 450	2	10	4.40	22.05	160 - 200	