

PRODUCT INFORMATION

SIFTRODE BRONZE CUSN

AWS A5.6 E CuSn-A
DIN 1733 E CuSn-7

DESCRIPTION

Basic coated tin bronze electrode for repairing copper and copper tin bronzes, brasses and phosphor bronzes. Suitable for surfacing on brasses, wrought bronzes (CuSn), mild steel and cast steel.

WELDING POSITIONS



Welding current: DC+
Suitable welding positions: PA, PB, PC, PE, PF, PG

TYPICAL WELD METAL COMPOSITION

| | |
|----|---------|
| Mn | 0.10 % |
| Cu | 93.00 % |
| Sn | 6.00 % |
| P | 0.20 % |

TYPICAL MECHANICAL PROPERTIES

| | |
|----------------------|-----------------|
| Ult Tensile Strength | ≥ 300-350 N/mm2 |
| Redrying | 300° / 2h |

MATERIAL TO BE WELDED

Base Materials: CUSn2, CUSn6, CUSN8, Copper, Grey cast iron

AVAILABLE FORMATS

| ELECTRODE RODS (MMA / SMAW) | | | |
|-----------------------------|-----------|-----------|---------------|
| Dia | 1.0kg Pkt | 5.0kg Pkt | Approx Pcs/KG |
| 3.2mm | RE3003201 | | 31 |
| | | | |
| | | | |
| | | | |

| CURRENT RANGE | |
|---------------|---------|
| Dia (mm) | Amps |
| 2.5 | 40-70 |
| 3.2 | 90-140 |
| 4.0 | 140-190 |

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email service@wholeweld.co.uk



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