

OK 94.25



Electrode for welding copper and bronzes, especially tin bronzes. It is also suitable for cladding steels and for small-scale repair work in weldable cast irons.

Applications:

For the repair and construction of parts in casting such as:

- valves
- pumps
- housings
- bearing surfaces

| | |
|-------------------------|---------------------|
| Classifications: | DIN 1733;(EL-CuSn7) |
| Approvals: | Seproz UNA 272581 |

Approvals are based on factory location. Please contact ESAB for more information.

| | |
|-------------------------|--------------|
| Welding Current: | DC+ |
| Alloy Type: | Copper alloy |
| Coating Type: | Basic |

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|------------|----------------|------------------|------------|
| ISO | | | |
| As welded | 235 MPa | 330-390 MPa | 25 % |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|------------|---------------------|--------------|
| ISO | | |
| As welded | 20 °C | 25 J |
| As welded | 0 °C | 20 J |

Typical Weld Metal Analysis %

| Mn | Cu | Sn |
|-----|----|-----|
| 0.4 | 93 | 6.5 |

Deposition Data

| Diameter | Current | Voltage | kg weld metal/ kg electrodes | Number of electrodes/kg weld metal | Fusion time per electrode at 90% I max | Deposition rate 90% I max |
|--------------|-----------|---------|---------------------------------|--|--|------------------------------|
| 2.5 x 350 mm | 60-90 A | 22 V | 0.71 | 77.0 | 39 s | 1.20 kg/h |
| 3.2 x 350 mm | 90-125 A | 24 V | 0.72 | 46.0 | 40 s | 1.90 kg/h |
| 4.0 x 350 mm | 125-170 A | 25 V | 0.74 | 30.5 | 41 s | 2.90 kg/h |