ELECTRODE ZIBRO 6

International standards

Material No.	2.1025
DIN 1733	EL-CuSn7
AWS A 5.6	E CuSn-C
AWS A 5.13	E CuSn-C

Approvals ---

Typical applications and characteristics

Basic-graphite special coated tin bronze electrode for repairing copper and copper tin bronzes (Cu-Sn 6-8 %), brasses, and phosphor bronzes. Also for dissimilar joints.
Recommended for surfacing on brasses, wrought bronzes (CuSn), mild steel and cast steel.
Good sliding and emergency running properties for bearings and contact surfaces of grey iron, type GG.

Operating temperature ---

Base materials

2.1010	CuSn2	2.1050	G-CuSn10	2.1086	G-CuSn10Zn
2.1016	CuSn4	2.1052	G-CuSn12	2.1090	G-CuSn7ZnPb
2.1020	CuSn6	2.1056	G-CuSn14	2.1096	G-CuSn5ZnPb
2.1030	CuSn8	2.1056	G-CuSn14		

Mechanical properties of all-weld metal

(typical values**)**

Tensile strength R_m N/mm²	**Yield strength $R_{p0,2}$ N/mm²**	**Elongation A_5 %**	**Hardness HB**
300	140	>20	approx. 110

Weld metal analysis (typical, wt. %)

Cu	**Sn**	**Mn**	**P**	**Fe**
Bal.	7	0,8	0,1	0,2

Current = + / ~ 50 V

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 200 °C + / - 10 °C (if required)

Dia./Length	**Amperage (A)**	**Pcs./ packet**	**Pcs./ carton**	**kg / 1000**	**kg / packet**	**kg / carton**
2,5 x 350	50 - 80	240	962	20,8	5,0	20,0
3,2 x 350	80 - 120	142	570	35,1	5,0	20,0
4,0 x 450	120 - 150	96	383	62,6	6	24,0
5,0 x 450	150 - 200	61	245	97,8	6,0	24,0

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Producer may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.