

GEMET 701DC

ELECTRODES FOR TIN-BRONZES AND SURFACING.

IDENTIFICATION

Gemet 701 DC, ECuSn-A

CLASSIFICATION

AWS SFA 5.6: ECuSn -A

DESCRIPTION

A special basic coated electrode for welding and surfacing of copper, brass and bronze. Deposited weld metal is free from porosity. The weld bead is smooth uniform and slag is easy to remove.

ALLOY BASIS : Cu, Sn, P

WELD METAL ANALYSIS (RANGE) %

Sn	P	Al	Pb
4.0 - 6.0	0.10 - 0.35	0.01 max	0.02 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	Hardness of the Weld Metal
250 - 350	20 % approx.	70 - 90 Brinell

TYPICAL APPLICATIONS

- Welding tin bronze (Phosphor bronzes)
- Bell metal (Cu + 20-25% Zn)
- Brasses
- Manganese Bronzes, pump impellers
- For welding copper base alloys to themselves and to steels or cast irons.
- To weld overlays shafts and engineering components to give a bearing surface and or corrosion resistant layer.

PROCEDURE

Prepare large "V" approximately 80 - 90°. Preheat to 300°C to reduce sluggish behaviour of weld pool.

REDRY : Re-dry if moist at 250 - 300°C for 1 -2 hrs.

WELDING CURRENT : DC (+)

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition DC (+) Amps	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	60 - 90	2	2 x 5 = 10

350	75 - 120	2	2 x 5 = 10	
4	350	100 - 160	2	2 x 5 = 10