

Standards

AWS A5.6 : E CuSn - C

**Chemical Composition of
Weld Metal % (Typical)**

Sn	Cu
7.0-9.0	Rest

Mechanical Properties

Tensile Strength (N/mm ²)	Elongation ((L ₀ =5d ₀) (%))	Hardness (HB)
min. 420	min. 25	155

Features and Applications

- Tin bronze electrode for coating and repairing parts made of copper, bronze, brass and for joining of these to steels, cast iron, nickel, nickel alloys
- Good resistance to corrosion, particularly attack by acetone and dry ammoniac, industrial atmospheres and salty air, seawater and acids
- It is also resistant to metal / metal friction
- Applications include joining welding of machinery components made of copper and its alloys, steels and cast steels a grey cast iron, such as piston arms, sprockets, guides, turbine and centrifugal, blades, fans, ship's screw propellers, motor collector and valve seats, for the application of braze surfacing on this materials

Welding Positions

MIG Wire

GeKa R4 L

TIG Wire

GeKaTec S4 L

Current Type

D.C.(+) / AC

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Package Weight kg
6031200023	3.20 x 350	1/8 x 14"	80 - 120	5
6031200024	4.00 x 350	5/32 x 14"	120 - 150	5

Approvals: SEPRO