



CEWELD E CuMn

TYPE Copper based electrode developed for joining and cladding.

APPLICATIONS CEWELD E CuMn is suitable for welding and overlaying Copper and Copper Alloys, Cast Iron and steel.

PROPRIÉTÉS Ductile welding deposit with high conductivity and corrosion resistance. The weld deposit is free from porosity and offers similar strength as most commercial copper grades. Thicker sections than 5 mm should be preheated up to approximately 500 °C.

CLASSIFICATION

AWS	A 5.6: E Cu
EN ISO	17777: E Cu 1893
W.Nr.	~2.1363
F-nr	31

CONVIENT POUR Cladding steel, Grey cast iron, Copper, Copper Alloys and dissimilar welding.
Mat.n: 2.0040, 2.0060, 2.0070, 2.0076, 2.0080, 2.0090, 20100, 2.0110, 2.0150, 2.0170,
UNS: C10100, C11000, C10300, C11020, C12000, C12200, C12250, C14200,
 CW008A, CW021A, CW023A, CR024A
 Cu-OF, E Cu, Cu-SE, Cu-SW, CU-SA, Cu-F, Cu-SF, Cu-D, Cu-DLP, Cu-DHP

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

Si	Mn	P	Fe	Sn	Ni+Co	Cu
0.25	2.5	0.08	0.1	0.7	0.2	96

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded		205	35	100 HB

ETUVAGE 140°C / 2 hr

GAS ACC. EN ISO 14175