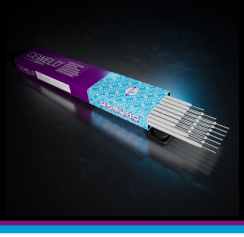

CEWELD E CuMn

certilas® THE FILLER METAL SPECIALIST

TYPE

Copper based electrode developed for joining and cladding.

APPLICATIONS

CEWELD® E CuMn is for joining and surfacing aluminum and bronze, for welding steel and cast iron with copper and bronze.

PROPERTIES

CEWELD® E CuMn show a 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

SUITABLE FOR

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

APPROVALS

WELDING POSITIONS

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

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded		205	35	100 HB

REDRYING

300°C / 2 hr

GAS ACC. EN ISO 14175