



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	<table><tr><td>AWS</td><td>A 5.6: E Cu</td></tr><tr><td>EN ISO</td><td>17777: E Cu 1893</td></tr><tr><td>W.Nr.</td><td>~2.1363</td></tr><tr><td>F-nr</td><td>31</td></tr></table>							AWS	A 5.6: E Cu	EN ISO	17777: E Cu 1893	W.Nr.	~2.1363	F-nr	31
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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															
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	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)	Rm (MPa)	A5 (%)	Hardness										
	As Welded		205	35	100 HB										
ETUVAGE	140°C / 2 hr														

GAS ACC. EN ISO 14175