



Ni+Co

0.2

Cu

96

CEWELD E CuMn

TYPE Elektrode auf Kupferbasis, entwickelt zum Verbinden und Plattieren (Cu Mn2, E Cu

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

> 17777: E Cu 1893 EN ISO

F-nr 31 W.Nr. ~2.1363

Cladding steel, Grey cast iron, Copper, Copper Alloys and dissimilar welding. SUITABLE FOR

Mat.n: 2.0040, 2.0060, 2.0070, 2.0076, 2.0080, 2.0090, 20100, 2.0110, 2.0150, 2.0170,

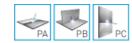
UNS: C10100, C11000, C10300, C11020, C12000, C12200, C12250, C14200,

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 No Approvals Found

WELDING POSITIONS



Si

TYPICAL CHEMICAL ANALYSIS OF WELD METAL

(%)

0.25	2.5	0.08	0.1

ALL WELD MECHANICAL **PROPERTIES**

Heat	R _{P0,2}	Rm	A5	Hardness
Treatment	MPa	MPa	(%)	Brinell Hardness
As Welded /		205	35	Avg. 100

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175