



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.								
PROPERTIES	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 EN ISO F-nr W.Nr.	A 5.6: ER Cu 17777: E Cu 1893 31 ~2.1363							
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 OF-Cu, E-Cu, SE-Cu, SW-Cu, F-Cu, SF-Cu, D-Cu, SD-Cu, SB-Cu, SA-Cu								
APPROVALS	No Approvals Found								
WELDING POSITIONS									
TYPICAL CHEMICAL	Si	Mn	P		Fe	Sn	Ni+Co	Cu	
ANALYSIS OF WELD METAL (%)	0.25	2.5	0.08		0.1	0.7	0.2	96	
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

Certilas The Filler Metal Specialist