



ECU Sn7

Coated Electrode for Copper Alloys -

Standards	
AWS/ASME SFA - 5.6	~ECuSn-C

Properties and Applications

Electrode for joining and surfacing of pure copper and copper alloys, steel, cast steel, grey cast iron such as piston arms, sprockels, guides, turbine and centrifugal blades, ship screw propellers, motor collectors etc. Suitable for surfacing weld on above materials. For surfacing application, the initial runs should be welded at the lowest possible amperage. To obtain the typical mechanical properties, preheat the workpiece to 350°C and maintain this heat throughout the welding operation. Possible to use both with AC and DC.

Materials		
DIN	Material	ASTM
Cu Sn 2	2.1010	C50700
Cu Sn 4	2.1016	C51100
Cu Sn 6	2.1020	C51900
Cu Sn 8	2.1030	C52100
G-Cu Sn 10	2.1050	C52400
Cu Sn 6 Zn	2.1080	
G-Cu Sn 7 Zn Pb	2.1090	
G-Cu Sn 6 Zn Ni	2.1093	
G-Cu Sn 5 Zn Pb	2.1096	

Typical Chemical Values of Weld Metal			
Type of Analysis	Cu	Sn	Diğer
Weld Deposit	92.00	7.00	1.00

Typical Mechanical Values of Weld Metal				
Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Hardness (HB)
As welded	130	290	-	110

Application Information

Welding Positions

PA PB PC PD PE PF

Polarity:

Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x300	40-75
3.25x350	60-90
4.00x350	110-150
5.00x350	180-220

Packaging Information						
Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
15001GJEM1	2.50x300	100 AD	1.77	9	16.20	VAC Box
15001GJEM2	2.50x300	102 AD	1.80	9	16.40	VAC Box
15001NJEM1	3.25x350	60 AD	2.11	9	19.20	VAC Box
15001NJEM2	3.25x350	59 AD	2.07	9	18.80	VAC Box
15001QJEM1	4.00x350	40 AD	2.14	9	19.50	VAC Box
15001QJEM2	4.00x350	39 AD	2.04	9	18.60	VAC Box
15001TJEM1	5.00x350	25 AD	1.99	9	18.20	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
 It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
 It has to be dried at 350°C for 2 hours.



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