



CEWELD E CuMn

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 EN ISO W.Nr. F-nr	A 5.6: E Cu 17777: E Cu 1893 ~2.1363 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)	R _m (MPa)	A5 (%)	Hardness
As Welded		205	35	100 HB

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175